Fully Automatic «L» sealer

MECKPACK STX

Installation, use and maintenance

Spare parts catalogue

MACHINE IDENTIFICATION DATA

Model: MECPACK STX

Serial number :
refer to the nameplate

Manufacturing date:
refer to the nameplate

EC' labelling :
refer to the nameplate

***Attached**: Declaration of conformity, Electric installation diagram*

The manual consists of 59 pages as follows:

- *Operating instruction cover page*
- *Identification data*
- *Service Centers*
- *Guarantee*
- *Operating instruction section*
- *Spare parts catalogue cover page*

Spare parts section

WARNING: for any doubts on the operating instruction content, ask for to the service centers specifying the page number and the paragraph inclusive of the demanded operating procedure

SAFETY INFORMATION

Read all the instructions carefully before use. In the case of uncertainty, contact the Technical Service for explanation, quoting the number of the page and the paragraph with the operating procedure in question.

Keep this instruction manual.

The information that it contains will help you to keep your machine fully efficient and to work in perfect safety.

Only connect the machine to a power supply equipped with earth and protected by a differential switch with an intervention limit of 0.03 A.

Do not use the machine in areas where the RH (relative humidity) exceeds 55%.

In the case in which problems should occur, do not intervene directly, but contact the technical service at ITALDIBIPACK or the authorized dealer. We refuse all liability for damage caused to people or property as a result of the direct intervention of the purchaser.

Before carrying out any operation, make sure that the general switch is on the "0" position, and remove the plug from the socket.

Do not open the control panel.

In the event of any unusual occurence, of any type, during machine operation; immediately press the EMERGENCY STOP button.

The machine must not be used in positions open to the outside environment and/or be exposed to the weather, nor in working areas in which there is steam, fumes, corrosive and/or abrasive powders, or fire/explosion risks, and in particular it must not be used in areas where flameproof electrical components are required.

LIMITS OF USE

The machine must not be used in the following locations: open-air environments and/or those exposed to the elements, environments containing steam, fumes corrosive and/or abrasive dusts, environments with fire or explosion hazards, and in any case wherever the use of fireproof components is required.

The electrical equipment operates correctly within an ambient temperature range of +5 °C to +40 °C and with relative humidity limits of less than 50% at 40 °C and less than 90% at 20 °C.

The machine is not suitable for operation in the presence of ionizing and other kinds of radiations (X-rays, lasers, microwaves, ultraviolet rays). The machine must be stored at a temperature between –5 °C and +55 °C.

QUALIFICATION OF THE OPERATORS

Only workers possessing the following qualifications may be allowed to use the machine:

Machine operator
An operator trained and qualified to operate the machine during functioning, comprising the use of the general switch and all the various controls present on the machine itself, assembly of the roll of plastic film, various adjustments depending on the format of the goods to be packaged, stopping and resetting of the machine.

Mechanical maintenance man
A qualified technician capable of running the machine like the machine operator and also to enable it to operate without the protective devices in the case of work on the mechanical parts for adjustments, maintenance or repairs.
He is not qualified to operate on the live electrical systems.

Electrical maintenance man
A qualified technician capable of running the machine like the machine operator and also to enable it to operate without the protective devices in the case of work on the electrical systems for adjustments, maintenance or repairs.

It is the responsibility of the user to define the qualified workers at the various levels of operation and to provide them with the appropriate training and operating instructions

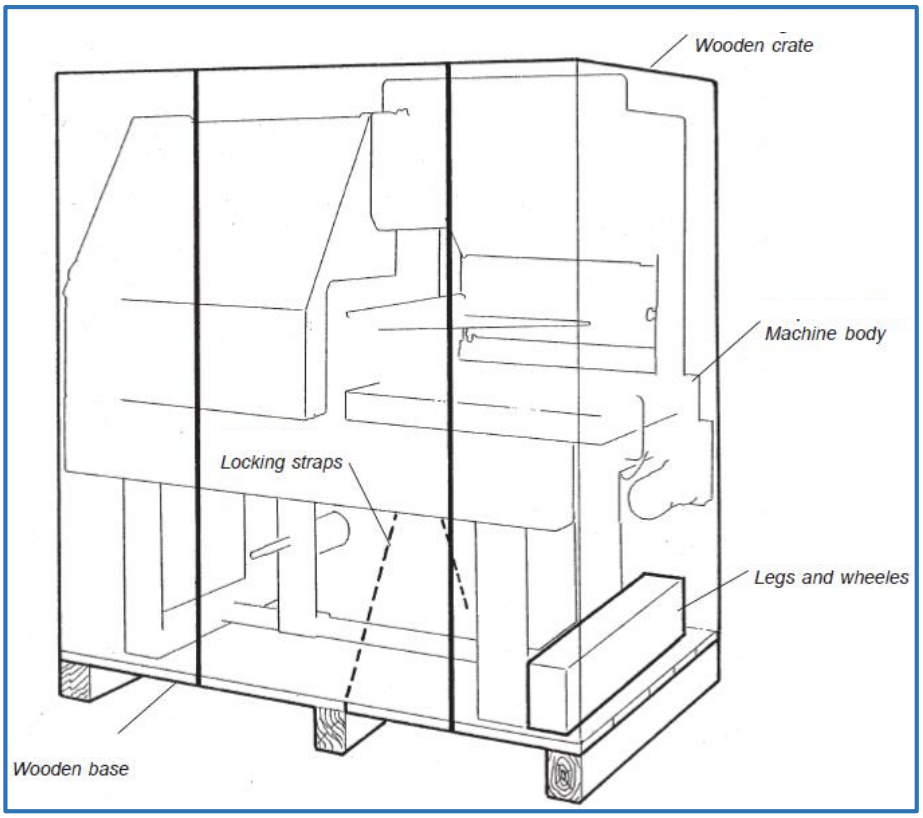
PACKAGING

Prestare particolare cura nel disimballo in quanto la macchina è costituita anche di parti in materiale plastico non resistenti ad urti violenti.
When unpacking the machine proceed carefully, as the machine itself has plastic components; and these are easily damaged by impacts.

The crate contains:

- *A reel carrier*
- *An off-cut (waste) winder*
- *A roller group for film winding*
- *Tensioning wheels*
- *Adjustable feet*

The discs of the waste rewinder are dismantled and fastened to one of the machine belts, to prevent them being accidentally damaged during delivery.



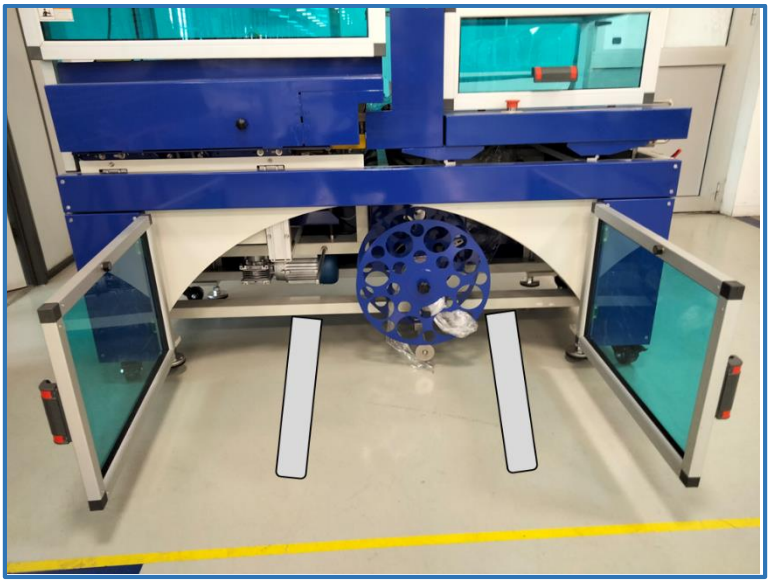
MACHINE ASSEMBLY

After removing the wooden crate, remove all the parts which have been dismantled and fastened to the machine body.

Remove the straps and the screws holding the machine to the wooden base and place the machine on the floor, using a forklift truck or similar.

Raise the minimum necessary and screw on the feet and wheels.

Use pallet truck or forklift.



Place the machine in its working position, taking care to conform to the regulations about minimum distances from the walls and other machinery, etc.

Place taking care to conformnto the regulation about safety distances.

The following image shows the positioning of the MECPACK STX automatic film welder machine in relation to a 5525 AX 1100 tunnel.

Adjust the machine feet so that the wheels do not touch the floor; and so that the machine is perfectly level.

Re-mount the waste rewinder discs. The one with a flange for fixing bolts, is mounted on the shaft first.

DESCRIPTION AND TECHNICAL CHARACTERISTICS

Automatic film welder MECPACK STX

This is an automatic angular welding machine with a photocell for detection of the material to be wrapped.

It can be used for packing any material: foodstuffs, and other materials, provided that they can be handled by the machine's feed belt.

The machine can be used as part of an automatic shrink wrapping line, or can be used independently with hand feeding by one or more operators.

A specially designed heat shrink tunnel can be used with the welding machine, or any other tunnel with dimensions which allow it to be fitted to the left-hand side of the machine at the outlet of the transporter belt.

THE FOLLOWING ITEMS MUST NOT BE PACKAGED:

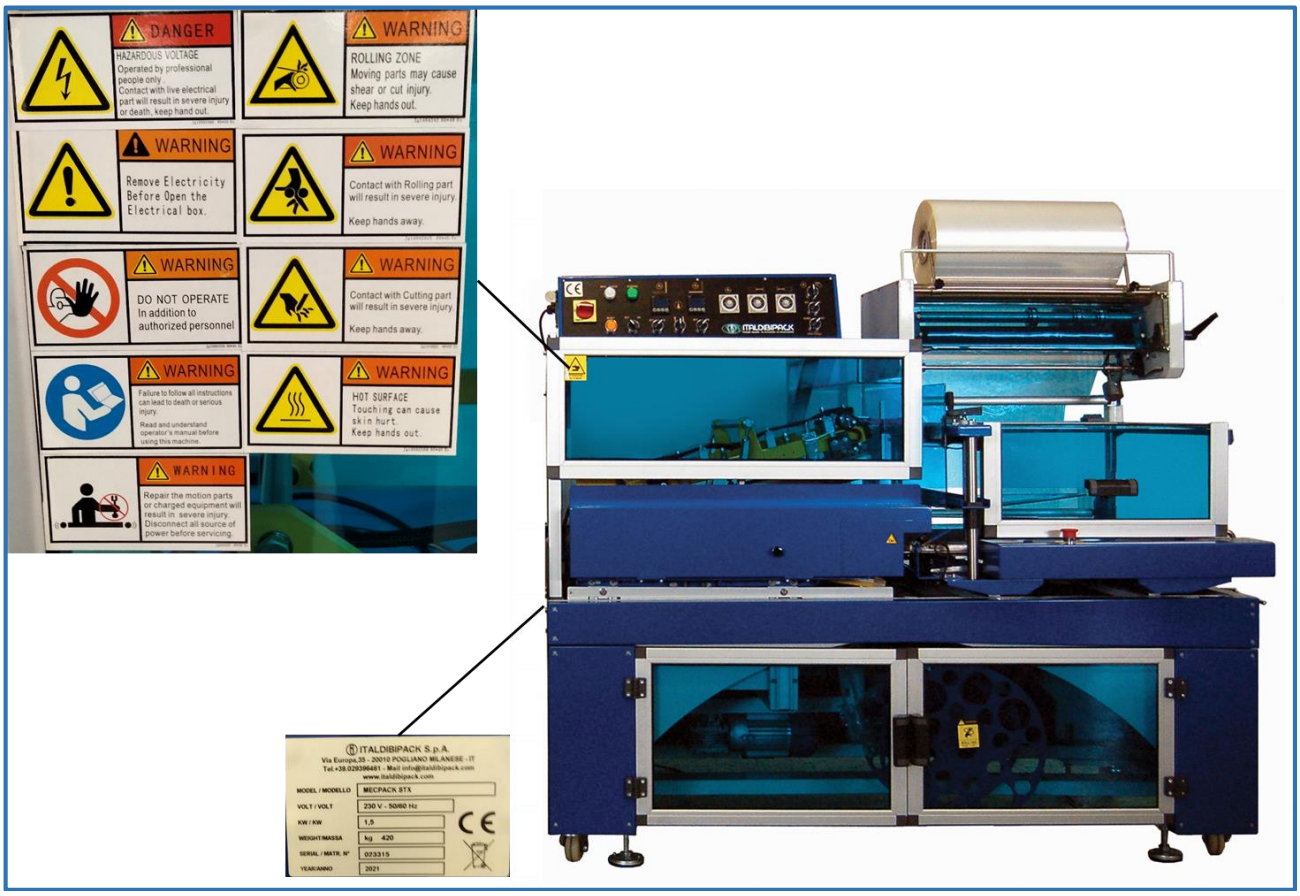
- ***Bulk granular products***
- ***Liquid or gelatinous products unless these are already packed in a primary container***
- ***Highly inflammable products***
- ***Explosive products***

In the case of use with food products, it is advisable to use plastic sealing film suitable for contact with food. In any case, we remind you that the machine is not suitable for contact with food products.

PLATES (warning signs and CE mark)
The machines are manufactured in conformity with the Machine Directive 2006/42/CE, the Low Voltage Directive (DBT) 2014/35/CE, the Electromagnetic Compatibility Directive 2014/30/CE.
All the components of the machine satisfy the requirements of the Directives and the CE mark testifies to its conformity.
The nameplate has the following data:
Model, Voltage (V/Hz), Power (kW), Weight (kg), Serial number, Year of manufacturing.

Legibility and conservation of the plates
The machine plates must be carefully maintained, so that all the plate data is legible.
In the case in which a plate should deteriorate and/or even one of the pieces of information shown should no longer be legible, request a new one from the manufacturer and see to its compulsory replacement.

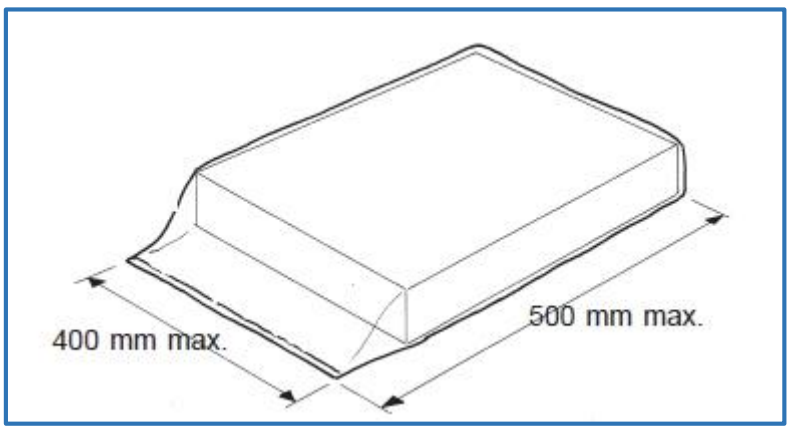
MARKING



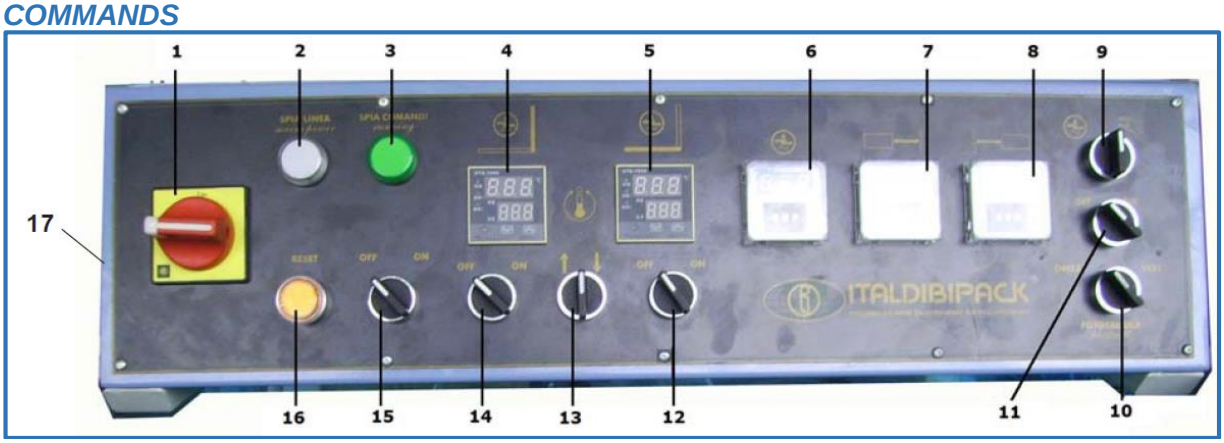
***WARNING**: The plates must not be removed or covered. It is forbidden place other plates on the machine without a wrotten authorization by the producer.*

DIMENSIONS

Machine weight	420 kg
Working level height	780 + 50 mm
Welding dimensions	550 x 450 mm
Installed power	2,2 kW
Compressed air	6 bar
Power supply	220 V, 50/60 Hz
Max film width	550 mm
Max pack sizes (according to the high) **(L x W x H)**	500 x 400 x 150 mm



COMMANDS



1 MAIN SWITCH
2 POWER LIGHT
3 CONTROLS' SIGNAL LIGHT
4 TRANSV. SEAL THERMOREGULATOR
5 LONG. SEAL THERMOREGULATOR
6 SEALING TIMER
7 TIMER, CONTROLLING THE FILM LENGTH BETWEEN THE END OF PRODUCT AND THE TRANSVERSAL WELDING BAR (TAIL)
8 TIMER, CONTROLLINGTHE FILM LENGTH IN PRODUCT FRONT (IN ADVANCE)
9 ROTATING SWITCH
UNCLOCK WISE SEAL
CLOCK WISE PULLING FILM BY CHAIN
10 VERTICAL HORIZONTAL PHOTOEYE SWITCH
11 KISSING CONVEYOR SELECTOR
12 LONG. HEATER ON OFF SWITCH
13 JAWS UP/DONW ROTATING SWICTH
14 TRANSV. HEATERON OFF SWITCH
15 CONVEYOR BELT ON OFF SWITCH
16 RESET BOTTON
17 MUS WASTE REEL SPEED AND TURNING COUPLE REGULATOR
18 COMPRESSED AIR PRESSURE REGULATOR WITH CONDENSATE DRAIN
19 INFEED WIDTH ADJUSTMENT STOP
20 EMERGENCY STOP BOTTON
21 INFEED HEIGH ADJUSTMENT HANDLE

CONNECTING THE POWER AND COMPRESSED AIR LINES

Electrical connection

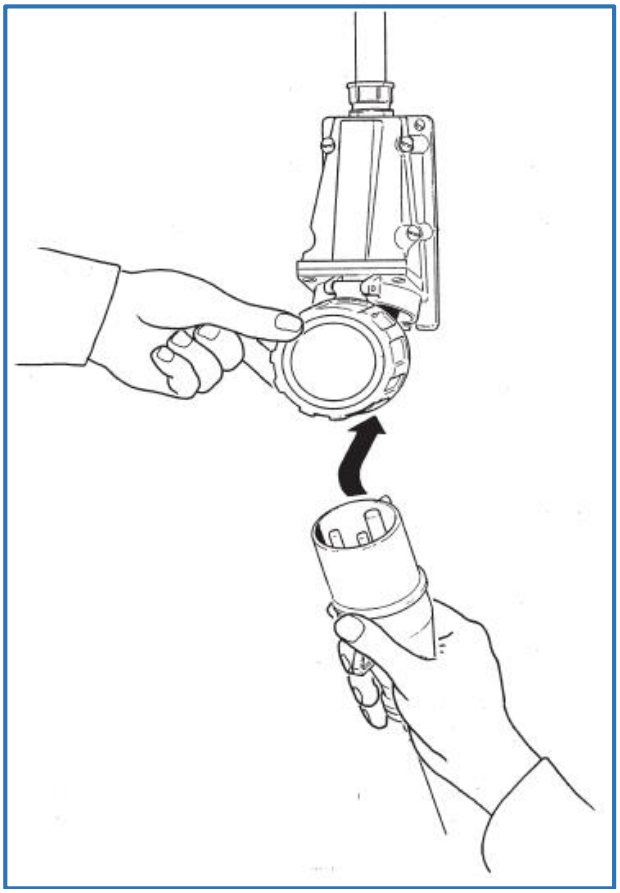
It is the user's responsibility to ensure that there is a suitable electrical connection available (Voltage, Board, Isolation Switch, Earth) in conformity with the current regulations.

In particular, it is advisable to use a differential switch with an intervention limit of 0,03 A.

The power supply must be appropriate for the machine and must comply with the margins set out in the relevant standards.
The CEI-EN 60204-1 standards apply in the case of the electrical apparatus of the machines, and consequently the power supply must have a maximum margin of 10% over the voltage value and a maximum margin of 1% in a continuous manner and 2% for a brief period of time over the value of the frequency.

The system must be equipped with an automatic release system with a differential automatic magneto thermic switch and an earth system that guarantees the minimum parameters required by the standards, observing in any case the specific requirements of the current laws in the country in which the machine is installed.

The machine must only be connected to the power supply by personnel professionally qualified and authorised. It is to be carried out using a plug and a power point which conform to the CEE regulations.



***Before connection**, check that the characteristics of the mains power supply match those indicated on the information plate on the machine.*

Check *that the general switch is in the "0" position.*

Do not make *any "mobile" type connections using extension leads and/or temporary cables, if necessary request the intervention of trained and qualified staff.*

Mark *the presence of the power cable(s) on the ground if a connection of another type is not possible and the passage of people is expected in the area of installation.*

Do not leave *cables on the ground in the area of vehicle transit.*

Connect the compressed air network to the appropriate attachment (1/4" gas) on the pressure regulator unit using a pipe of 8 mm diameter minimum (int. diameter 6 mm min.): ***max. operating pressure 0.6 MPa (6 bar).***

Illumination

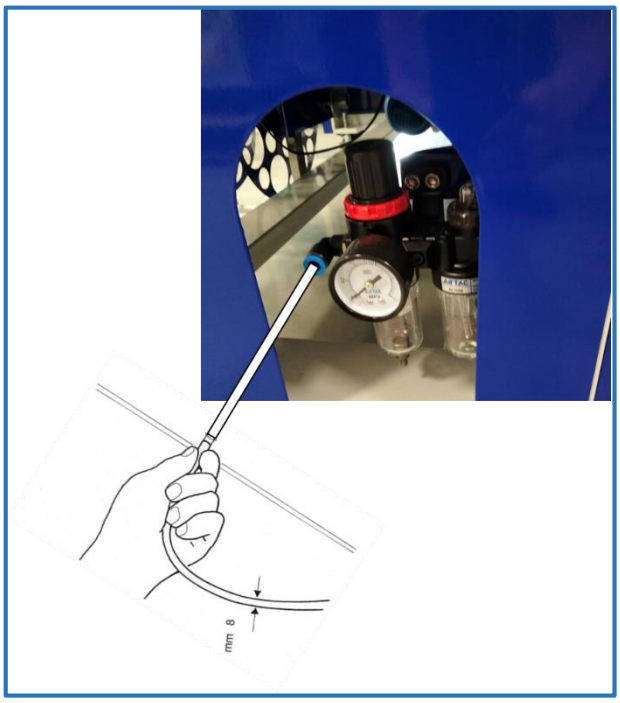
The machine does not have a lighting system.

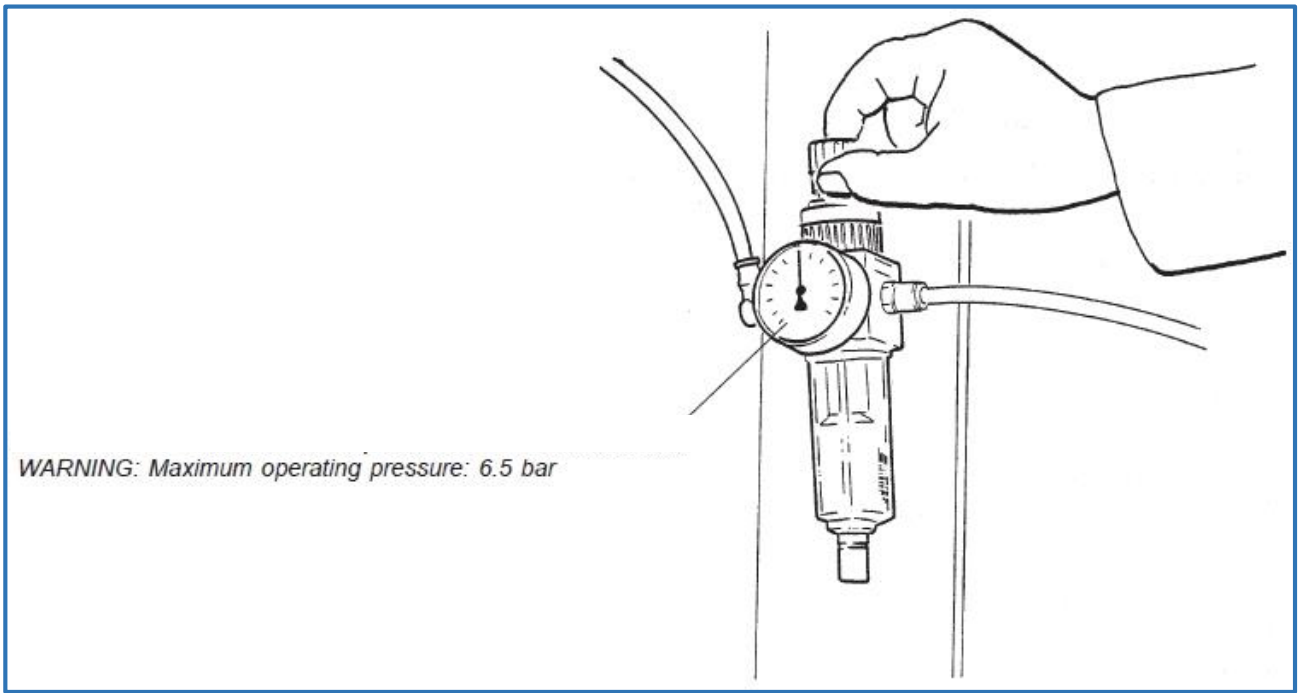
The room lighting level must therefore be sufficient to give shadowless adequate illumination and to guarantee that the machine can be safely operated for the purpose required.

If there is a need to carry out local maintenance on any part not adequately lit for this purpose, a portable lamp must be used. Care must be taken that this does not produce shadows in the intervention zone which will reduce the effective visibility.

Pneumatic connection

Connect the machine to the compressed air distribution system using the connector on the pressure reduction unit with the condensate separator. Remember that the maximum operating pressure required by the machine is 6,5 bar.

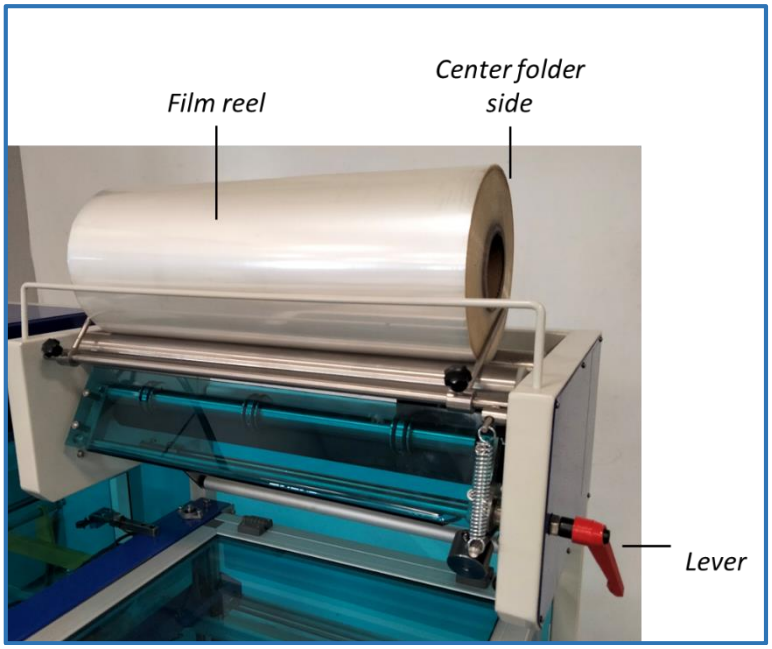




Should the air pressure shown by the gauge differ from the operating pressure, use the knob on the pressure reduction unit until the value shown is correct. Lift and turn the knob clockwise to increase the pressure and anticlockwise to reduce the pressure, as required.

When the correct pressure is established, lock the knob by pressing it downwards

Mount a reel of film which is a suitable width for the product to be wrapped, by following the instruction plate fastened to the right-hand reel support, and those given below, in this manual.



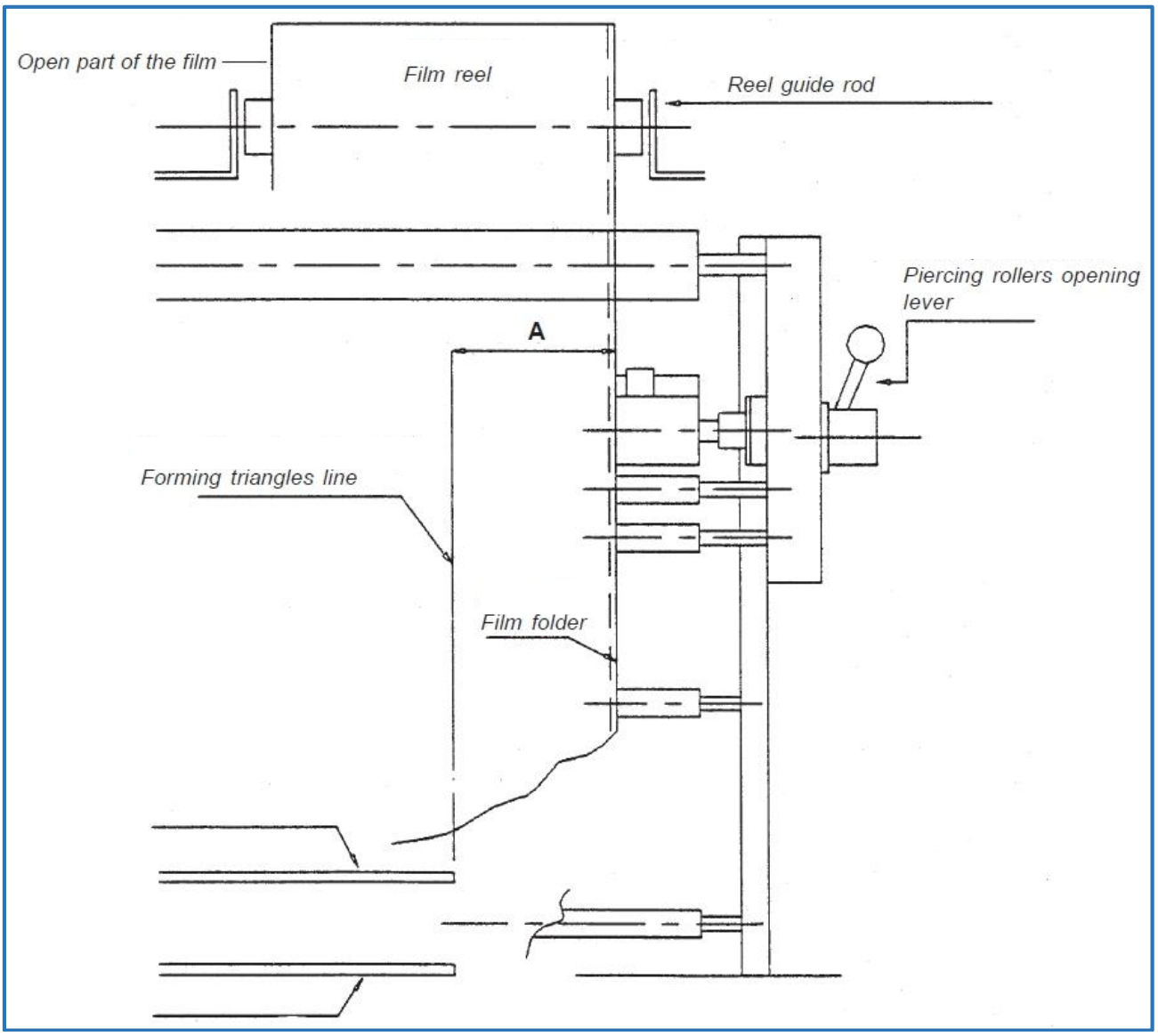
WARNING: Position the reel on the rollers so that the open part is on the left

Move the lever which opens the film traction piercing rollers.
Insert the end of the film roll between the rollers of the film traction unit

	*REQUIREMENT: Use proper PPE.Pay careful attention to the piercing rollers whilst the film is being threaded, as they are fitted with pointed needles*

WARNING. Weights of more than 15 kg require two operators to handle them

Position the film reel above the rollers and fit the reel guide rod so that it guides the reel whilst leaving it free to rotate.

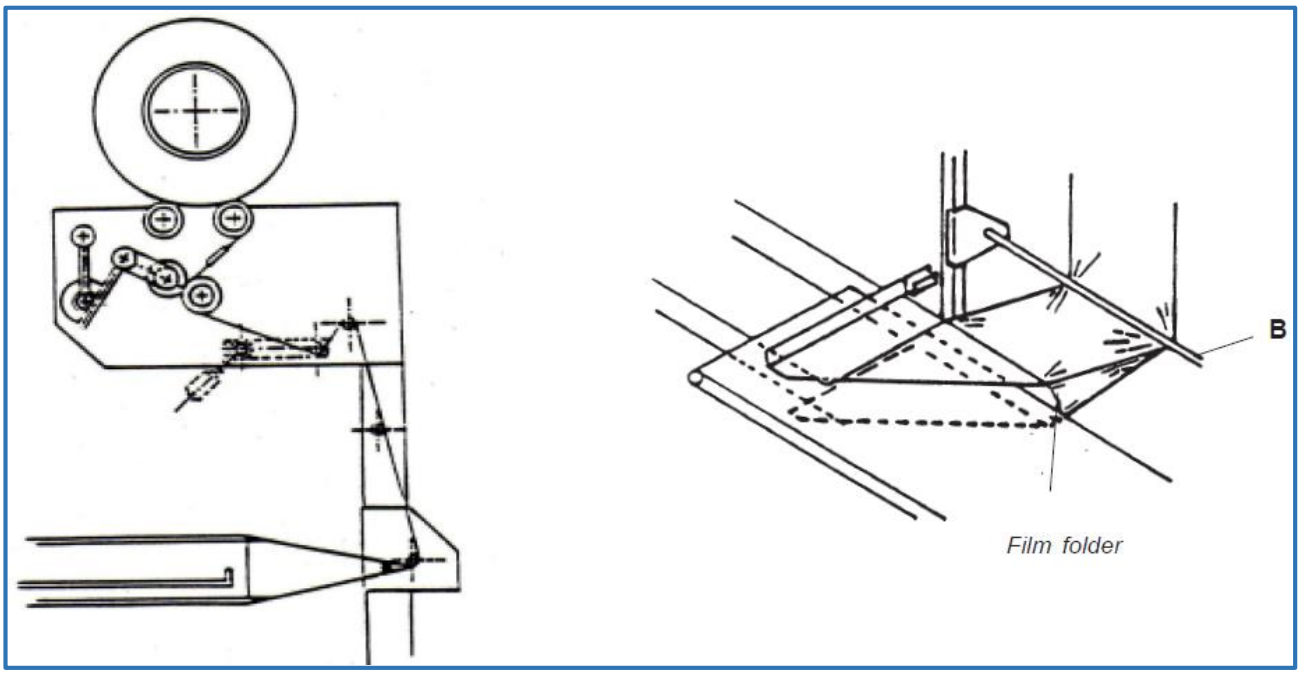


Remember that the distance (A) between the film folded part and the forming triangles must increase as the distance between the upper and lower triangles increases.

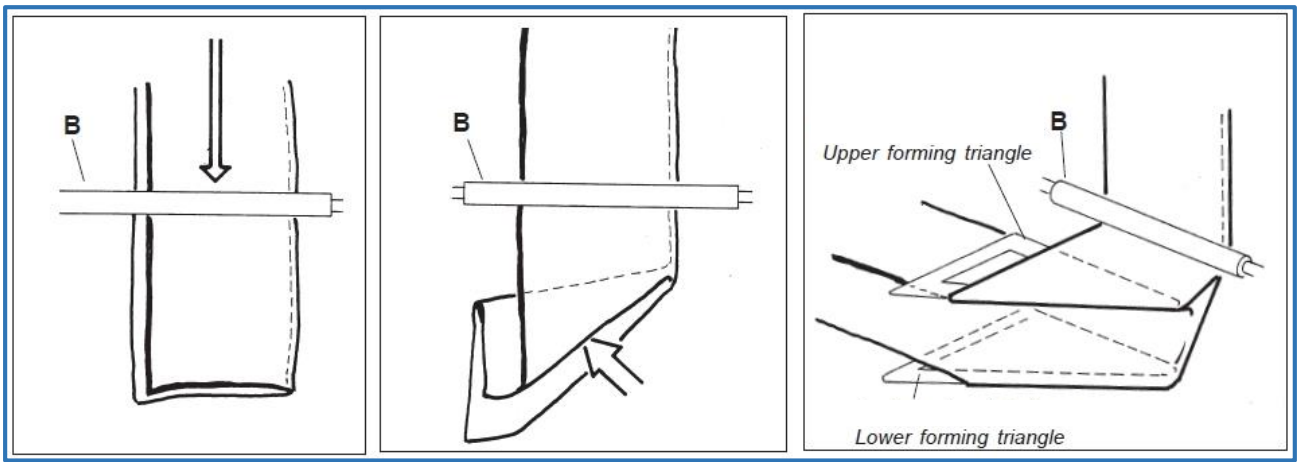
Check that roller (B) is perfectly centred in relation to the upper and lower forming triangles. Check that the shaft (C) will be inside the 2 film layer.

Threading the film

Position the reel on the rollers so that the open part is on the left.
Unwind the film, passing it through the rollers and the film openers. Then pass it over the forming triangles.

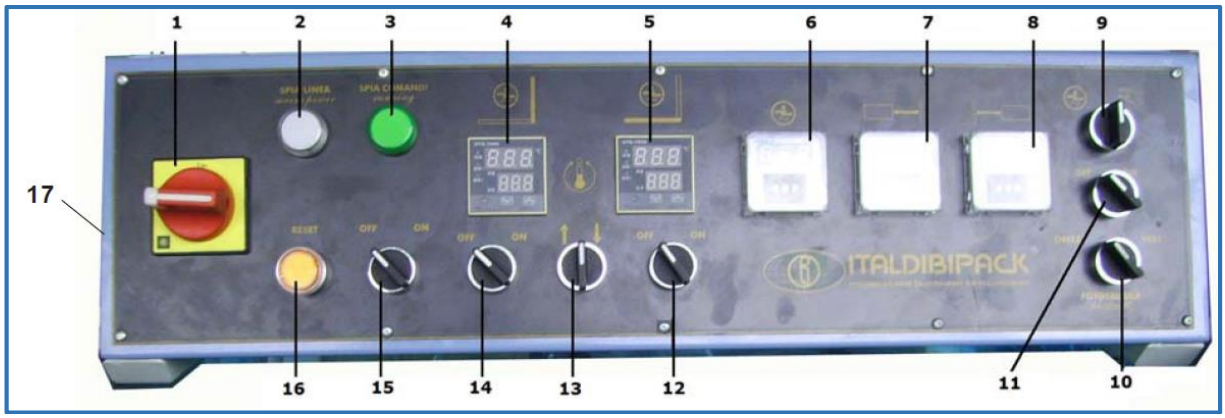


WARNING: the unwind system do not works if the safety guards are open or the machine is Emergency status



WARNING : Remember to close the spiked-pulling rollers' opening lever, before carrying out the first weld

MACHINE START-UP AND USE



Turn the main (1) switch to position 'I'.

Set the temperatures controllers (4) AND (5) for the horizontal and vertical welding bars (selector 9). The basic temperature setting for both controllers is 200 °C approx, but requires to be adjusted according to the type of plastic film being used, its thickness and the room temperature

WARNING: The temperature must never be set above 230 °C

Set the welding time using the keypad (6). Initially set the time: 1,5 seconds.

Then turn unclock wise the manual weld knob (9) and hold it in position for some seconds. After some cycle will be possible to decrease the sealing time up to 1 second. This is merely an indicative value and will need to be adjusted according to the type and thickness of the plastic film being used.

After passing the film over the forming triangles, take it as far as the film pulling group and thread it between the chaines.

Re close the front safety guard.

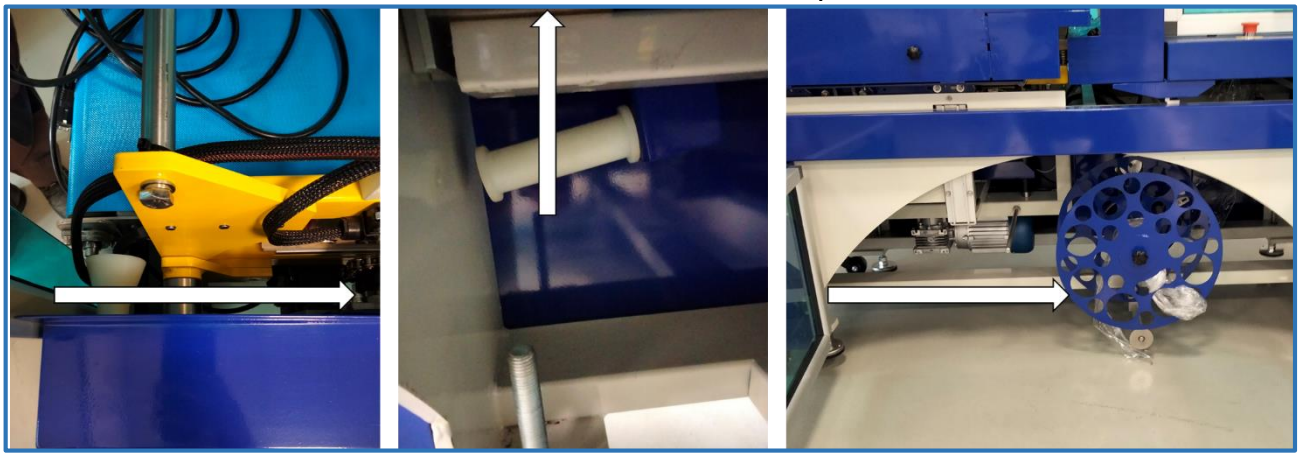
Move the film forwards turning clock wise the knob (9) for about 1 second, or until a length not exceeding the longitudinal welding bar).

Turn clock wise the same know to make the sealing.

At this point the machine will carry out its first automatic welding cycle.

Repeat the operation several times until there is a sufficient length of waste film for it to be fastened to the external waste winder on the lower part of the machine.

Pass the scrap around the different rods according the pictures



Switch ON the switch sited on the MUS (17) and adjust the film tension so that it is taut but will not break. Use the knob on the MUS to carry out this adjustment.

Turn the the belt movement switch (15) to ON.

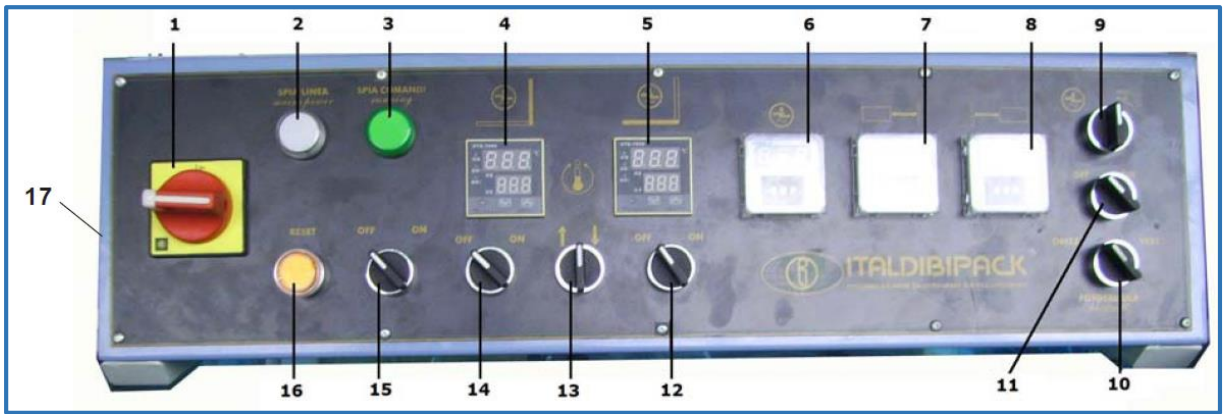
Adjust the height of the upper forming triangle, and the entrance width in accordance with the dimensions of the product to be wrapped.

Choose the photoeye turning the selector (10).

Insert the approcheable conveyor option, if necessary, turning the selector (11).

The machine is now ready to work in automatic mode. It is only necessary to place the products to be wrapped on the in-feed belt, with the back of the packs touching the rear guide, so that they are carried correctly into the wrapping and welding zone.

ADJUSTMENTS



*The **length of the envelope** can be set to match the length and height of the product.*
Use the timer (7) (tail timer) to increase or decrease the lenght of the bag back to the pack.

It is suggested to start with a setting of 0.2 for low products and 0.5 for higher ones. If necessary, adjust these values to a more suitable setting, by test,

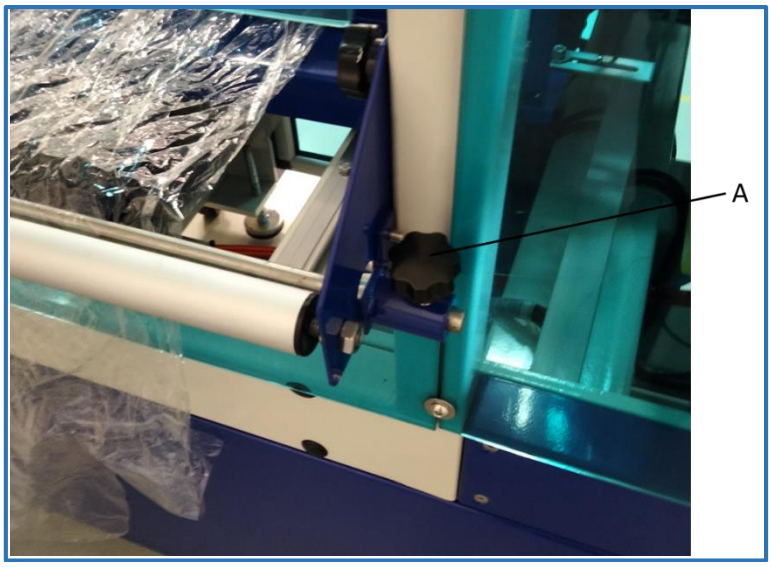
Use the timer (8) (head timer) to increase or decrease the lenght of the bag in front to the pack.

It is suggested to start with a setting of 0 for low products and 0,5 for higher ones. If necessary, adjust these values to a more suitable setting, by test.

*To set the **height**, so that the product passes through the machine, turn the handle at the front of the upper forming triangle support, and move the structure up or down until the product passes freely.*

*To set the **width clearance**, loosen the knob A and move front / back the infeed belt body.*

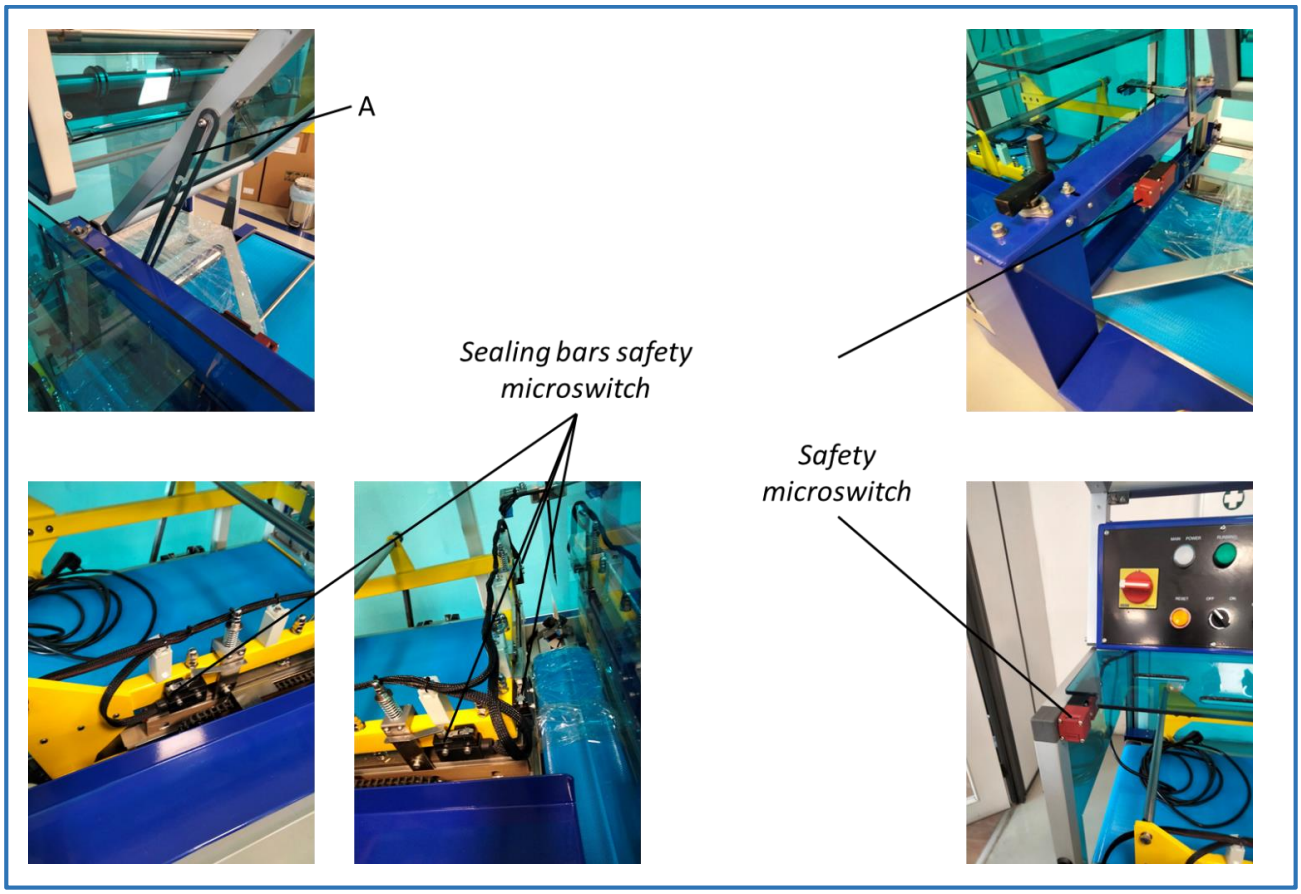
It is possible to adjust the position of the horizontal photoeye moving the knob C.
WARNING: Emitter and receiver will be alined



*It is possible to adjust the **height of the sealing bar** closing position according to the height of the product using the selector (13).*
For product up to 80 mm high it need to seal will be approx 25 mm higher that coneyor belt.
For higher product it need to increase the sealing height approx 10 mm if the height of the pack increase of 20 mm.

SAFETY SWITCHES

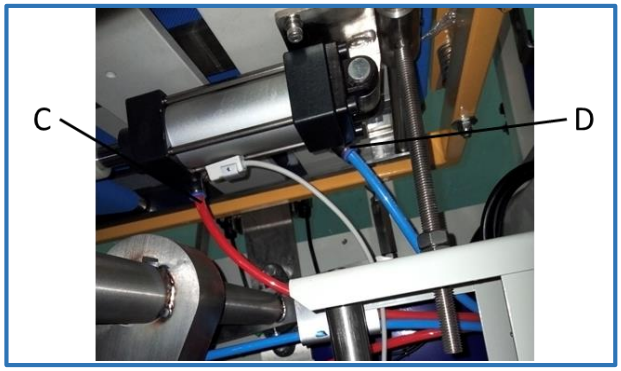
In the machine are installed safety switches that stop the working cycle if you open the safety guards.
To restart it need to move in OFF position the switch (15) and after press the reset botton (16).
To close the infeed conveyor belt safety guard, it needs to lift up the arm (A).



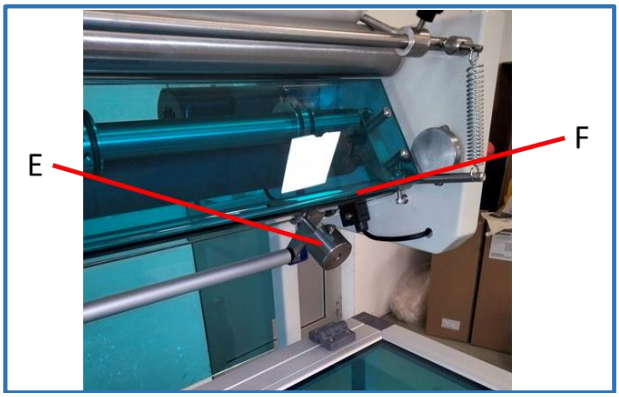
OTHER ADJUSTMENTS ONLY FOR TECHNICIANS

*It is possible to adjust **the open and close speed of the sealing jaws**.*
Turning the screw (A) you adjust the closing speed; turning the screw (B) you adjust the opening speed.

*It is possible to adjust the **open and close speed of the approcheable conveyor***
Turning the screw (C) you adjust the opening speed; turning the screw (D) you adjust the closing speed.



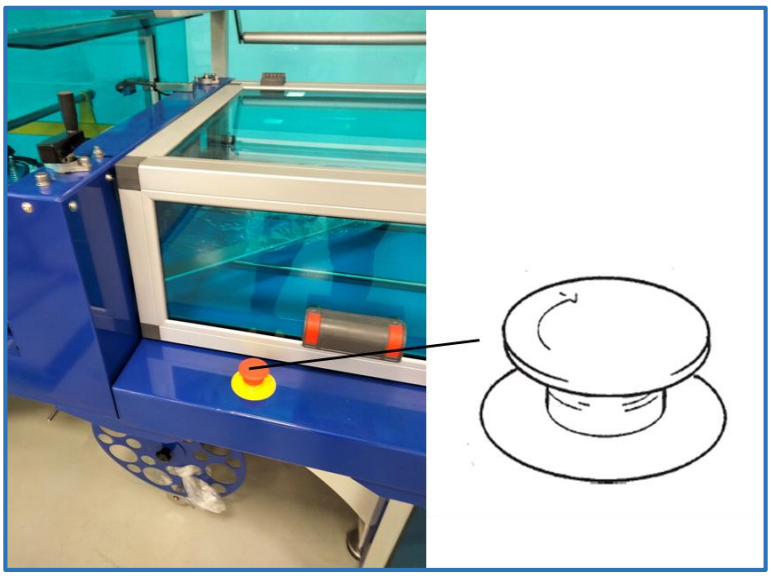
It is possible to adjust the weight of the unwind dancing roll and the start position of the unwind motor.
Moving back the conter weight (E) the film tension decrease.
Tourning the camme (F) you change the motor start microswitch intervention.



DURING MACHINE WORKING

WARNING: Never insert objects into the welding zone when the machine is working. Make sure that nothing is placed on the in-feed belt; other than product to be wrapped

WARNING: Press the EMERGENCY STOP button immediately, whenever there is an operating irregularity

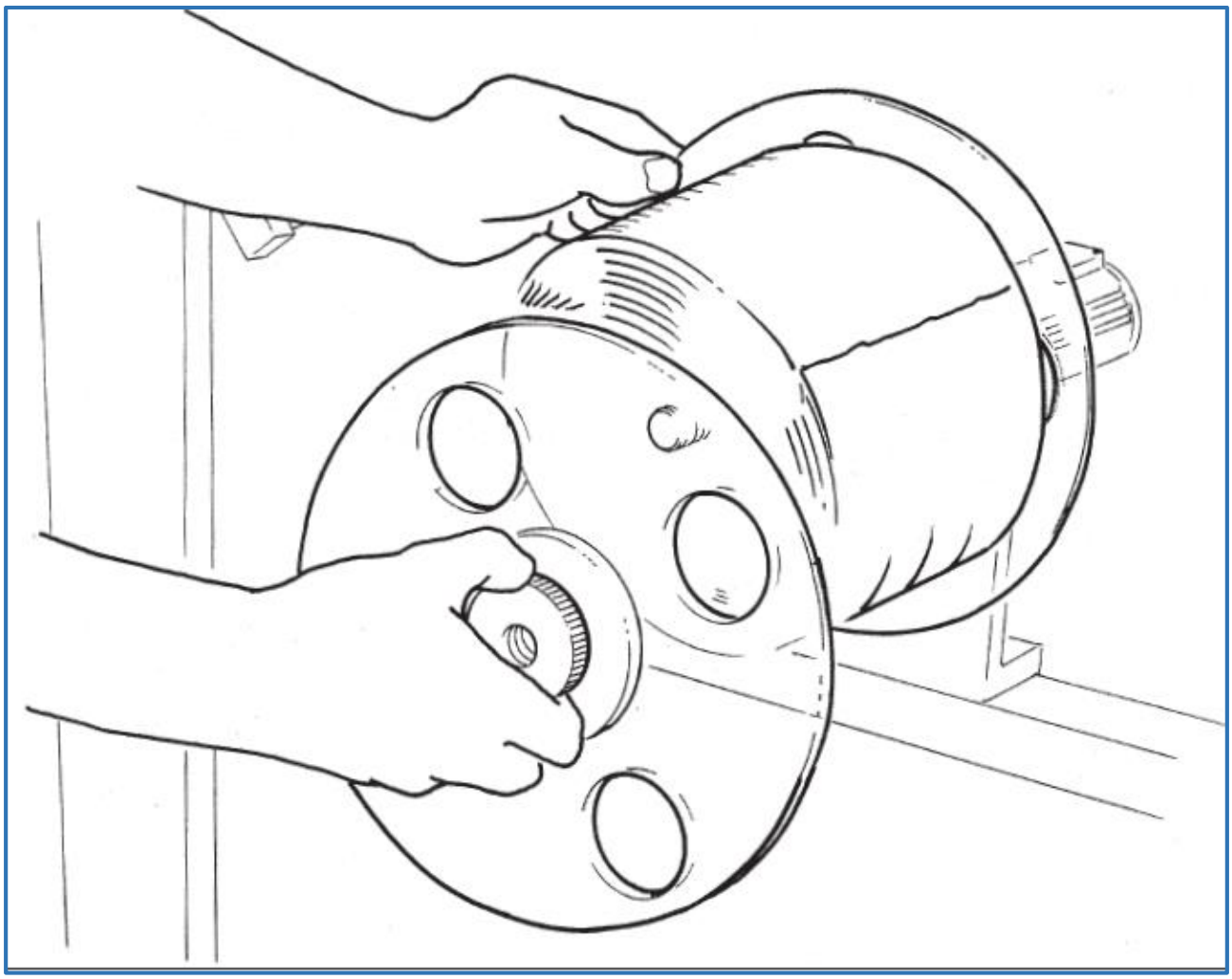


To re-obtain the normal working condition, turn clockwise the pushbutton and keep it in a 'raise' position to consent the functioning and after give again the consent using the reset button (16).

WARNING: The machine has a safety system which ensures that the machine stops automatically if a product pack becomes blocked between the welding bars. To restart, remove the pack and press the reset button 16. Before to do this is better to turn OFF the selector 15. The same operation needs to be carried out every time the EMERGENCY STOP button has been used to stop the machine; when the machine is re-started following the open safety guards, or when it needs to be re-started after any other type of unscheduled stop.

REMOVING OF THE SCRAP

To remove the waste plastic, remove the black knob and the front reel disc, whilst holding the back reel. Remove the waste leaving a length sufficient to re-fasten it to the empty reel.



PHROIBITED USE

Using the machine for operations that are not permitted, its improper use and lack of maintenance may cause dangerous situations for personal safety as well as jeopardize the intrinsic functionality and safety of the machine.

- **NEVER** permit operation of the machine by psychophysically unfit people or those who have not carefully read the contents of this manual.
- **NEVER** use the machine in unsuitable environmental conditions.
- **NEVER** use the machine with “mobile” type electrical connections using temporary or non-insulated cables or extension leads.
- **NEVER** leave the machine unattended when it has been enabled for operation.
- **NEVER** use the machine for purposes other than those for which it is designed.
- **NEVER** modify the components of the machine with the aim of increasing productivity.
- **NEVER** use the machine whilst wearing flowing or wide-sleeved garments.
- **NEVER** use the machine if the contents of this manual have not been fully understood.
- **NEVER** carry out cleaning or extraordinary maintenance operations without having first deactivated the machine and removed the plug from the power socket.
- **NEVER** carry out temporary or emergency repairs: call the service center.
- **NEVER** use the machine as a resting surface and do not place any object on it that is not used for normal packaging operations.
- **NEVER** touch the sealing bar when opening the hood after a packaging operation.
- **NEVER** carry out packaging operations with a broken sealing element: replace it immediately.

The MECPACK STX automatic welder works with plastic film. Therefore, there can be a build-up of plastic residues on the welding bars, which causes imperfect welds or failure to cut the bag. To prevent this the welding bars must be cleaned periodically (at least once a day), by wiping them with a soft cloth whilst they are hot (minimum temperature 90 °C. to 100 °C) [this prevents the protective Teflon bar coatings being damaged].

WARNING: Before carrying out any operation on the machine, ensure that the main power isolation switch is in the “0” position, and remove the machine powerplug from its socket

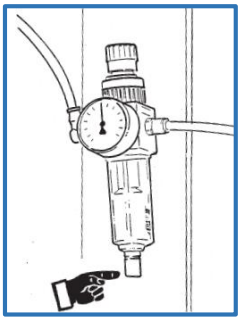
	*REQUIREMENT: Use proper PPE*

	*WARNING: Risk of burns*

WARNING: Never use abrasive cleaners, brushes or metal blades to remove deposits

After cleaning the welding bars, wipe them down with a cloth soaked in silicone oil or grease.

Periodically, empty the water separator glass reservoir, of the compressed air pressure controller. To do this unscrew the bottom screw of the reservoir a few turns.



All the painted parts and all the plastic safety guards must be cleaned with a soft cloth, which has been dampened with detergent for cleaning glass. Do not use water, solvents or powder products as these may damage or scratch the surfaces.

SCRAPPING AND DISPOSAL

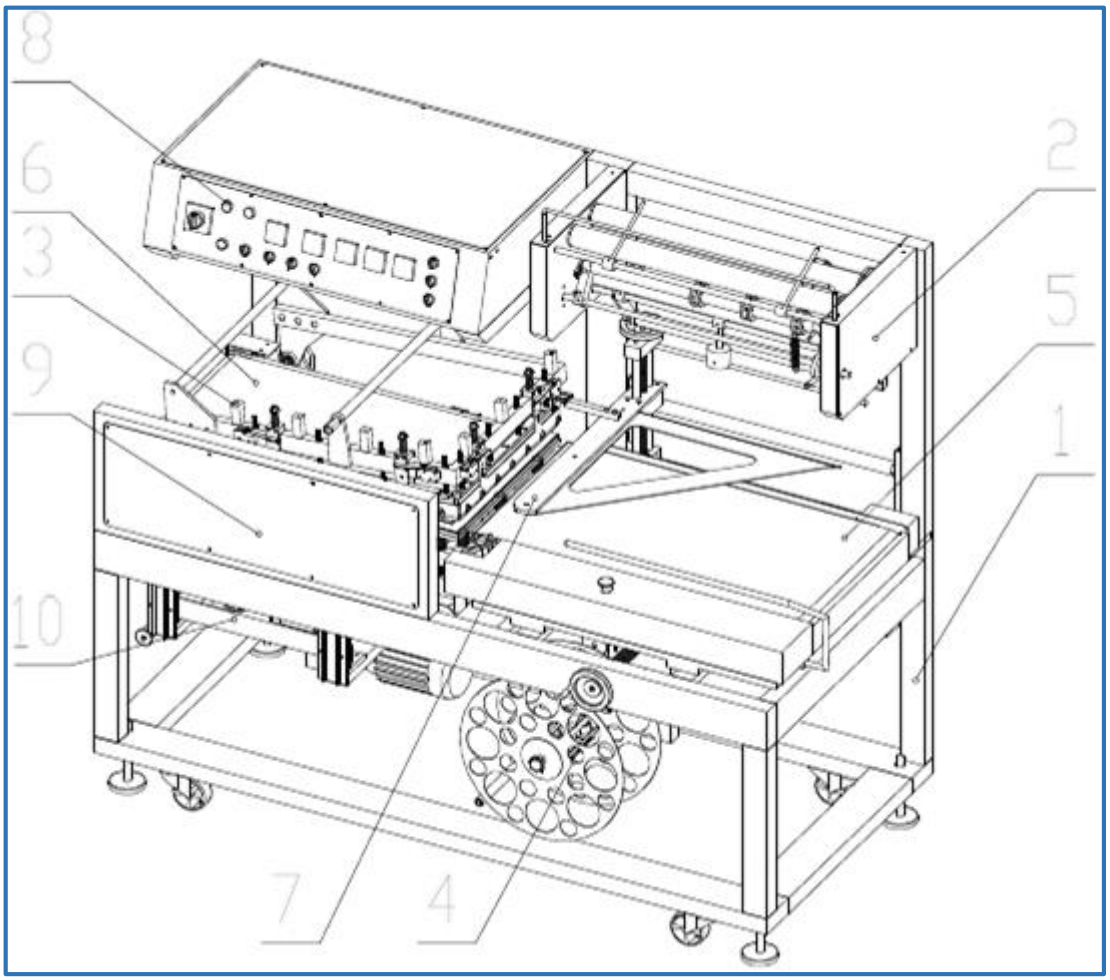
Should the machine be scrapped, provide for the differential disposal of its components (i.e. metal, oils, greases, plastic and rubber, etc.), preferably turning it to authorised specialized companies and in any case in compliance with regulations in force in terms of industrial and solid waste disposal at the installation site.

WARNING: Never place the machine within working areas: it might become a serious danger for people, specifically children, and animals. <u>The machine owner shall be liable for damages</u>.

Fully Automatic «L» sealer

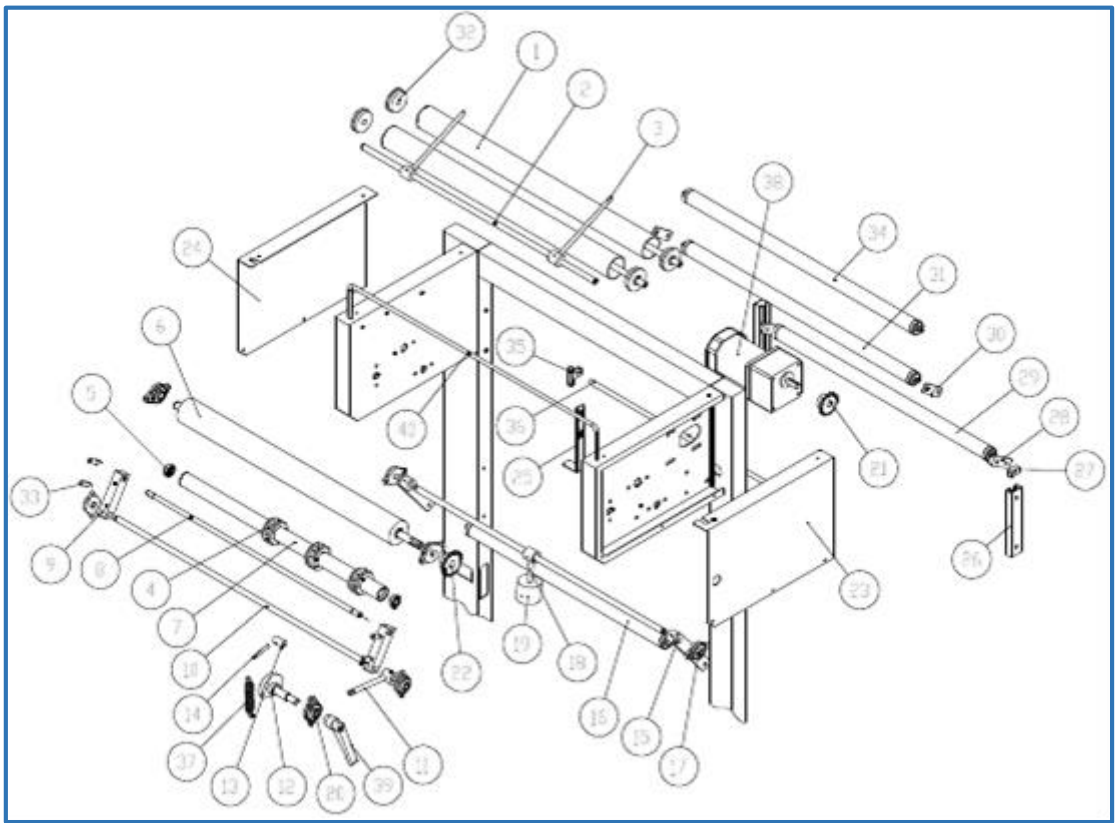
MECKPACK STX

Spare parts catalogue



MACHINE

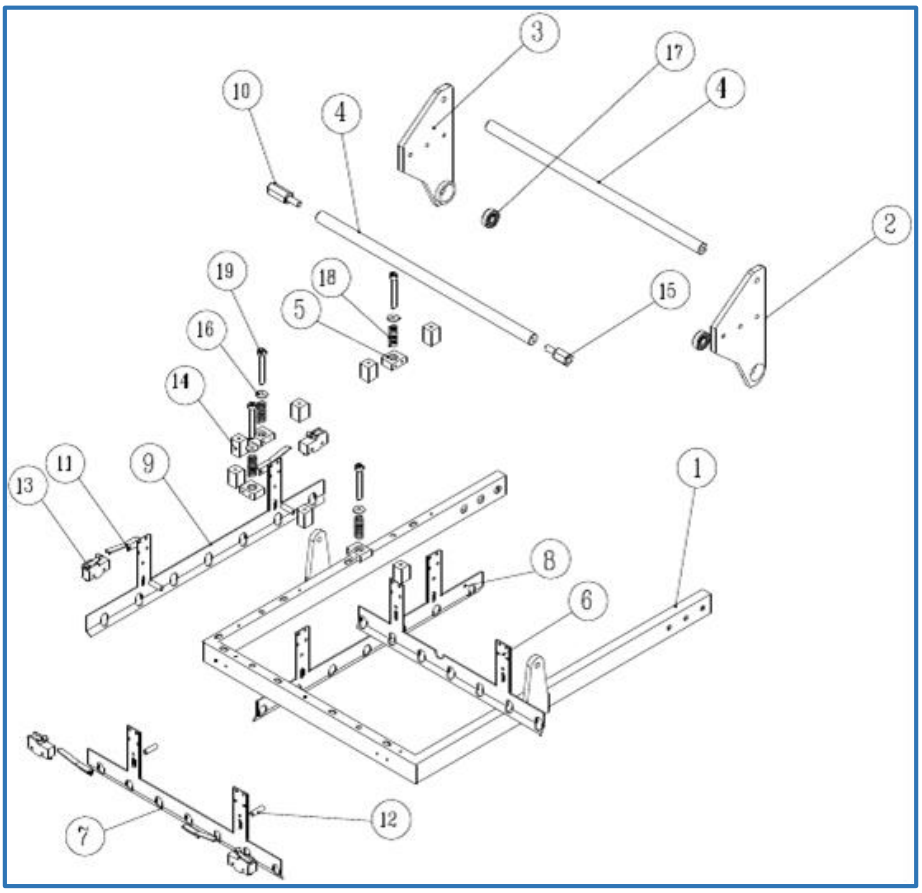
N./Nr.	Description
1	Machine frame
2	Film reel group
3	Cutting group
4	Scrap group
5	Loading belt group
6	Unloading belt group
7	Film treatment group
8	Control panel
9	Film collecting group
10	Lifting up and down group



FILM REEL GROUP

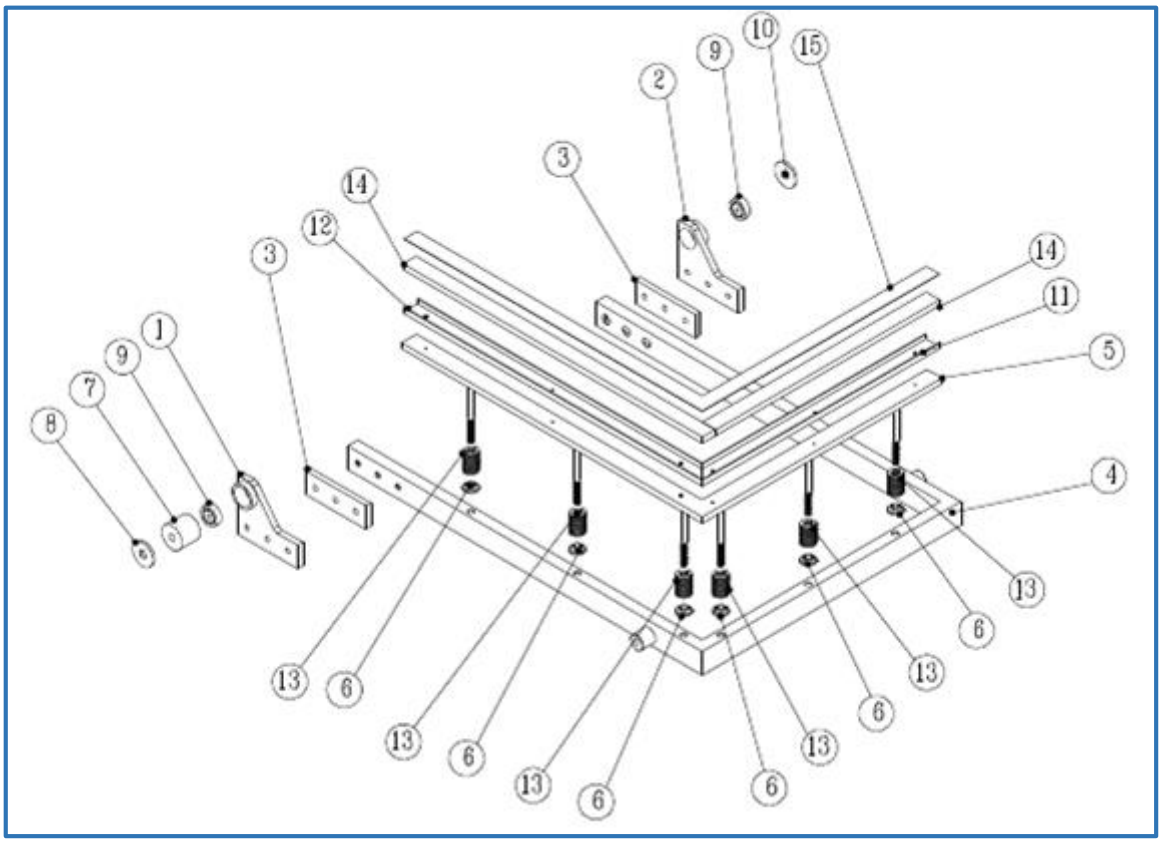
Nr	Code	Description	Q.ty
1		Filminstallation roller	2
2		Film installation shaft	3
3		Film block pole	2
4		Needle wheel	3
5		Bearing	2
6		Film sending main roller	1
7		Needle roller	1
8		Needle wheel shaft	1
9		Eccentric block	2
10		Oscillating rod	2
11		Compaction base	1
12		Compaction eccentric wheel	1
13		Tension spring pin fixing block	1
14		Tension spring pin	1
15		Film sending connection block	2
16		Swaying film roller	1
17		Bearing K001	4
18		Adding weight block link pole	1
19		Adding weight block	1
20		Bearing K002	3
21		Motor chain wheel	1

22		Passive chain wheel	1
23		Left cover	1
24		Right cover	1
25		Position limit piece	1
26		Transition roller fixing frame	2
27		Fixing block 2	2
28		Fixing block 1	2
29		Transition roller 3	1
30		Fixing piece	2
31		Transition roller 2	1
32		Roller end cap	2
33		Mat column	4
34		Transition roller1	1
35		Shaft support SK - 10	1
36		Separating film pole	1
37		Tension spring	1
38		Motor	1
39		Handle	1
40		Block shaft	1



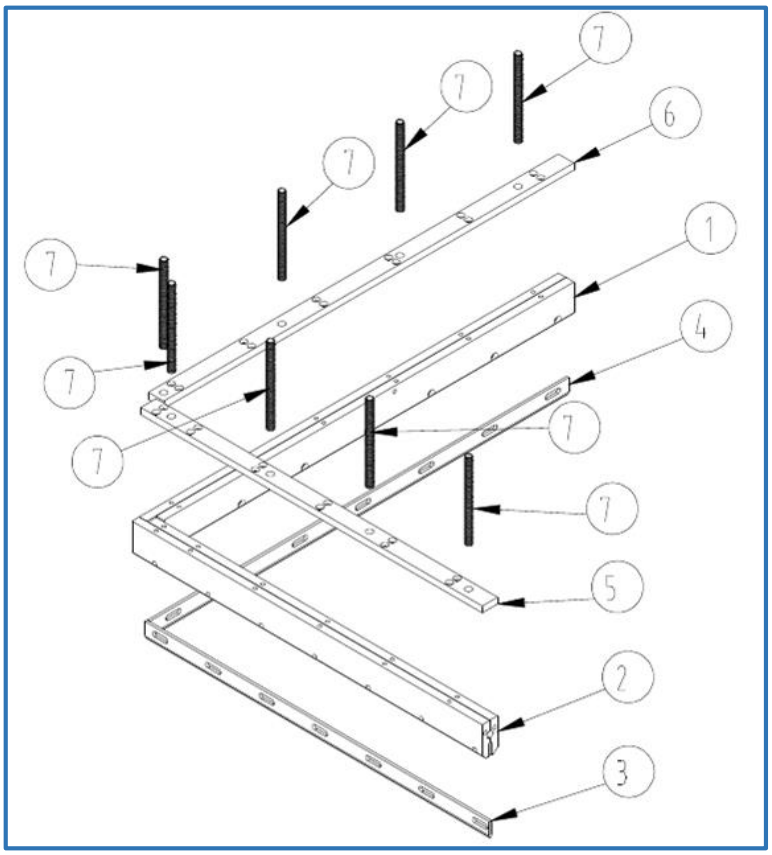
CUTTING GROUP

Nr.	Code	Description	Q.ty
1		Up cutting film frame	1
2		Up connection board 1	1
3		Up connection board 2	1
4		Cutting film supporting pole	2
5		Pressing film board adjusting block	4
6		Pressing film piece 1	1
7		Pressing film piece2	1
8		Pressing film piece 3	1
9		Pressing film piece 4	1
10		Supporting pole fixing part A	1
11		Touch switch frame	4
12		M5 screw cover	4
13		Micro active switch	1
14		Wire mat block	8
15		Supporting pole fixing part B	1
16		Sring pad	4
17		Bearing	4
18		Compressed spring	4
19		Screw	4



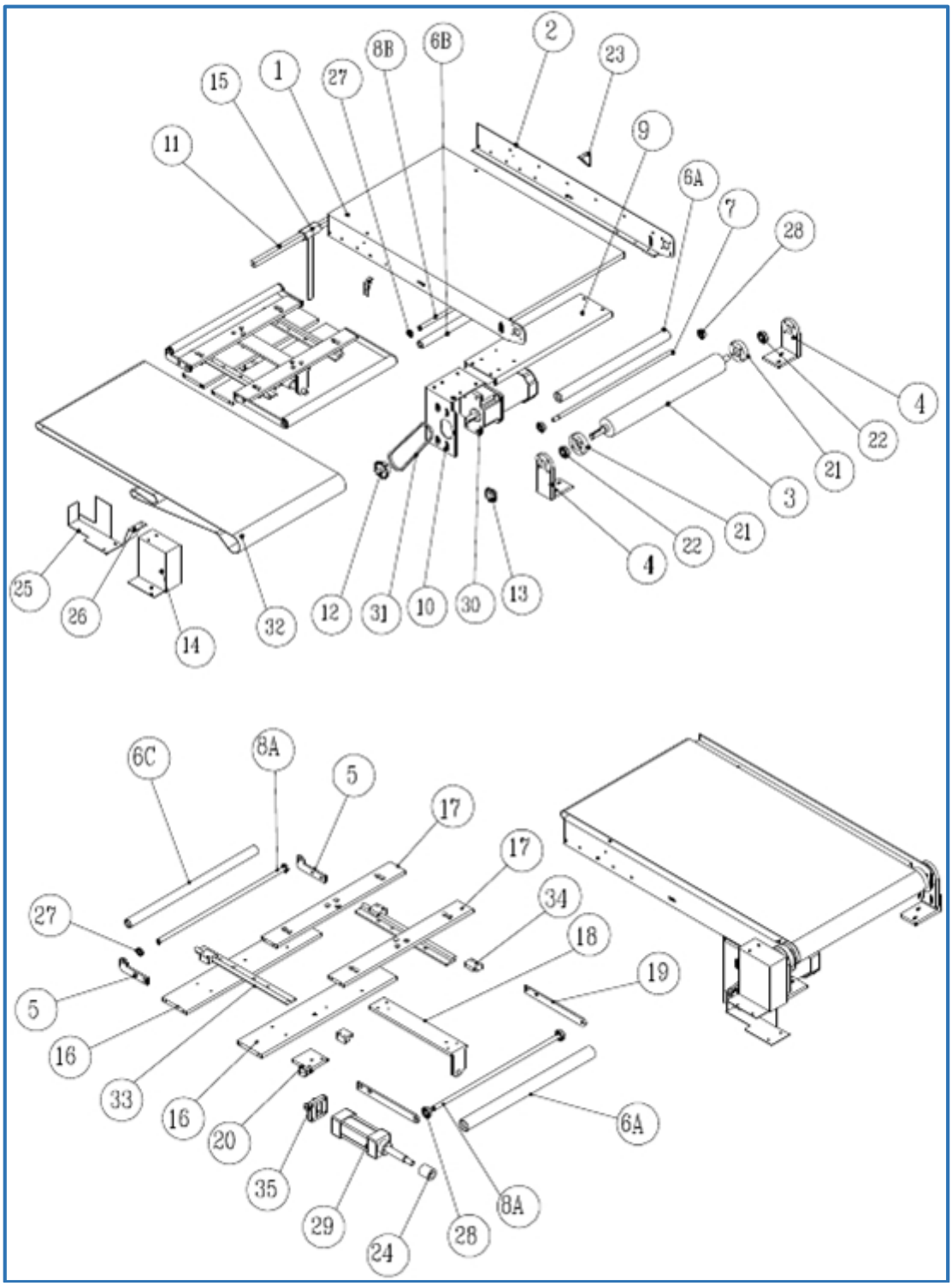
CUTTING GROUP

Nr.	Code	Description	Q.ty
1		Down connection board1	1
2		Down connection board2	1
3		Connection block	2
4		Down cutting film frame	1
5		Cutting film groove pad	1
6		Spring pad	6
7		Fixing column	1
8		Backup ring	1
9		Bearing	4
10		Pressing ring	1
11		Cutting film groove 1	1
12		Cutting film groove 2	1
13		Compressed ring	6
14		Silica gel	1 kg
15		High temperature adhesive tape	0,033 m^2



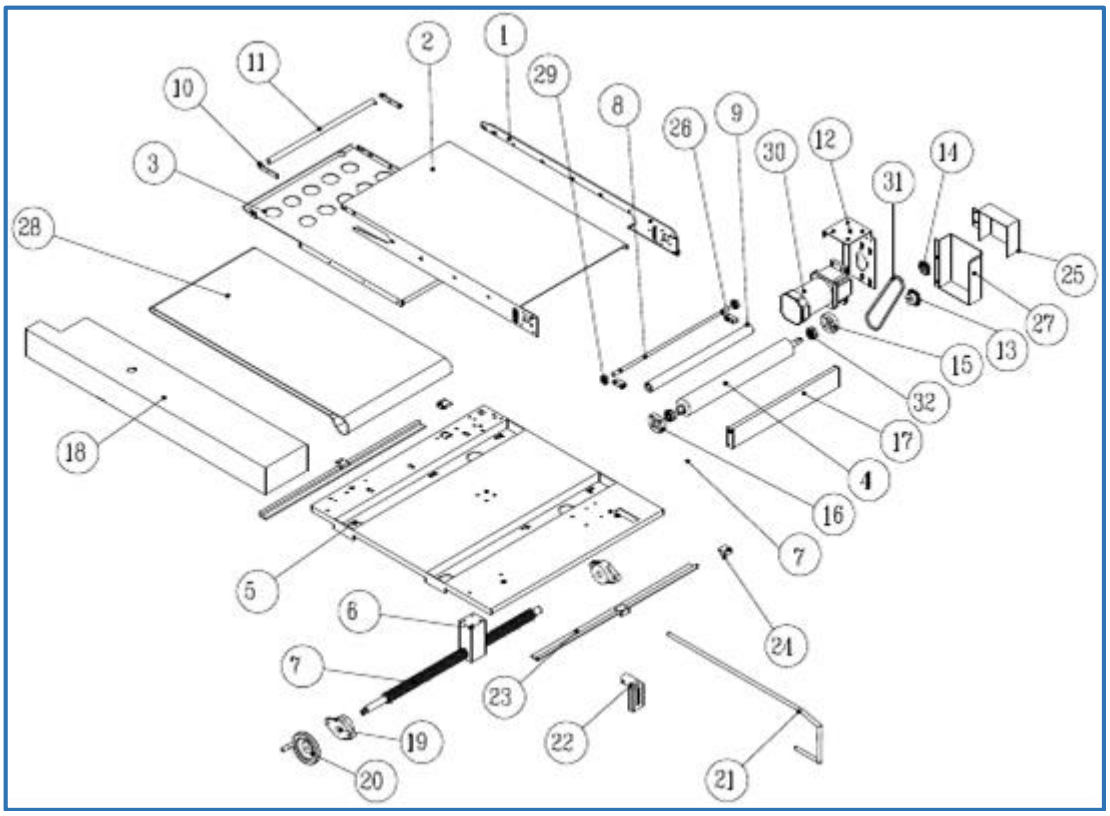
CUTTING GROUP

Nr.	Code	Description	Q.ty
1		Section-bar blade frame 1	1
2		Section-bar blade frame 2	1
3		Blade 1	1
4		Blade 2	1
5		Horizontal connection board	1
6		Vertical connection board	1
7		Screw pole	8



UNLOADING BELT GROUP

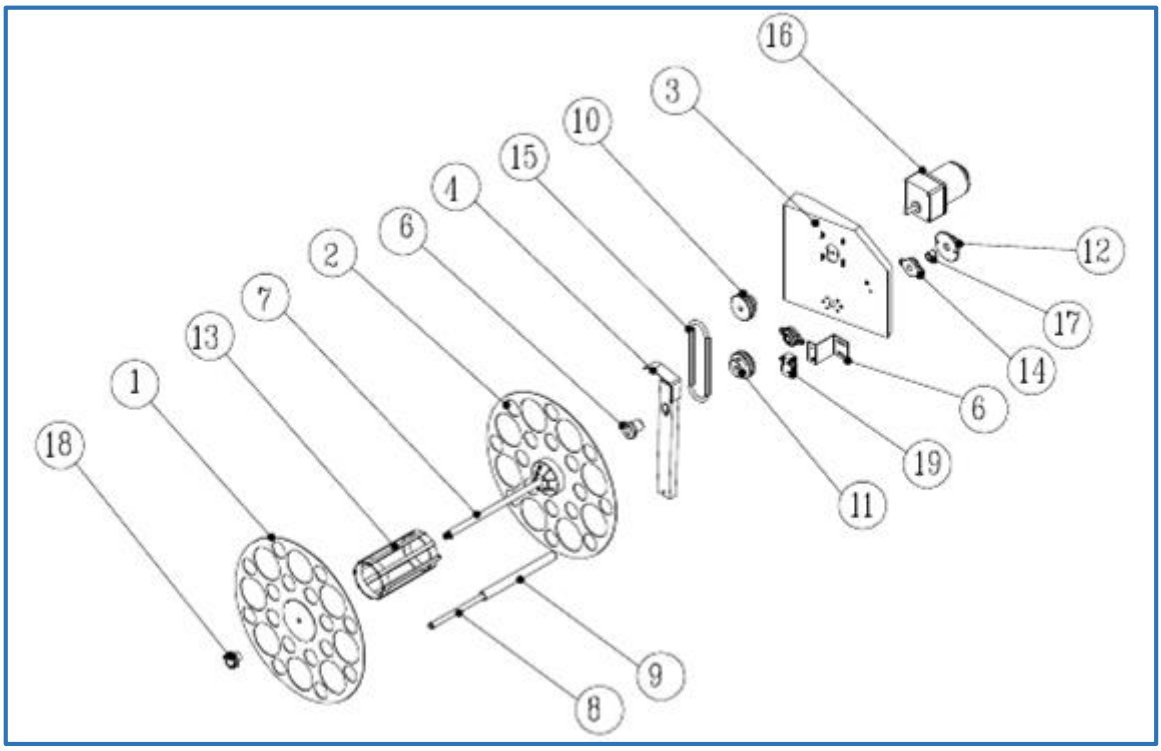
Nr.	Code	Description	Q.ty
1		Left side board	1
2		Right side board	1
3		Back main roller	1
4		Bearing pedestal fixing block	2
5		Flex part	2
6A		Adjusting roller A	2
6B		Adjusting roller B	1
6C		Adjusting roller C	1
7		Adjusting shaft	1
8A		Passive shaft A	2
8B		Passive shaft B	2
9		Connection board	1
10		Motor base	1
11		Supporting pole	1
12		Chain wheel 1	1
13		Chain wheel 2	1
14		Motor cover	1
15		Supporting base	1
16		Sliding bar base	2
17		Sliding board	2
18		Cylinder fixing board	1
19		Shaft connection board	2
20		Cylinder fixing part	1
21		Bearing pedestal fixing block	2
22		Bearing	2
23		Fixture block	2
24		Cylinder stop collar	1
25		Chain wheel guarding board	1
26		Back up plate	1
27		Bearing 6800-Z	4
28		Bearing 6000-Z	4
29		Cylinder SC40X50-S	1
30		Motor	1
31		Chain	1
32		Belt	1
33		Sliding rail	2
34		Sliding block	4
35		Cylinder base SC40-CB	1



LOADING BELT GROUP

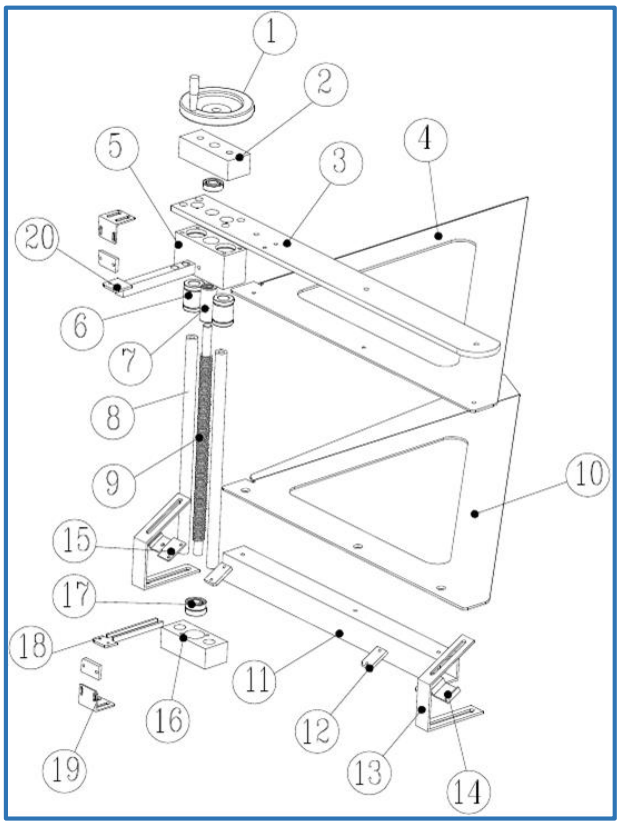
Nr.	Code	Description	Q.ty
1		Right side board	1
2		Left side board	1
3		Baseboard	1
4		Front main roller	1
5		Sliding board	1
6		Moving nut	1
7		Moving lead screw	1
8		Adjusting shaft	1
9		Adjusting roller	1
10		Shaft fixing part	2
11		Passive shaft	1
12		Motor base	1
13		Chain wheel 1	1
14		Chain wheel 2	1
15		Bearing pedestal 1	1
16		Bearing pedestal 2	1
17		Front belt conveyor covering board	1
18		Cover	1
19		Bearing pedestal	2
20		Handle	1
21		Catch pin	1

22		Adjusting block	1
23		Sliding rail	2
24		Sliding block	4
25		Chain wheel cover	1
26		Adjusting block	2
27		Chain wheel cover	1
28		Belt	1
29		Bearing6000-Z	2
30		Motor	1
31		Chain	1
32		Bearing 1202	2



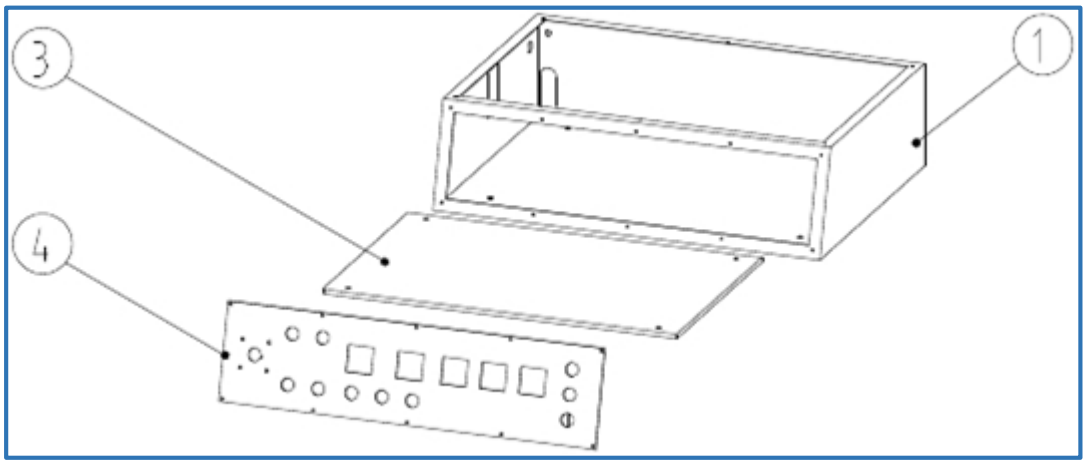
SCRAP GROUP

Nr.	Code	Description	Q.ty
1		Collecting unserviceable film check ring 1	1
2		Collecting unserviceable film check ring 2	1
3		Collecting unserviceable film motor	1
4		Guiding unserviceable film frame	1
5		Unserviceable film frame fixing ring	1
6		Limit switch frame	1
7		Collecting unserviceable film shaft	1
8		Guiding unserviceable film roller shaft	1
9		Guiding unserviceable film roller	1
10		Active O-sized belt wheel	1
11		Passive O - sized belt wheel	1
12		Bearing pedestal	1
13		Unserviceable film cage	1
14		Bearing K002	2
15		O - sized belt	1
16		Motor	1
17		Bearing HF1416	1
18		Handle	1
19		Micro active switch	1



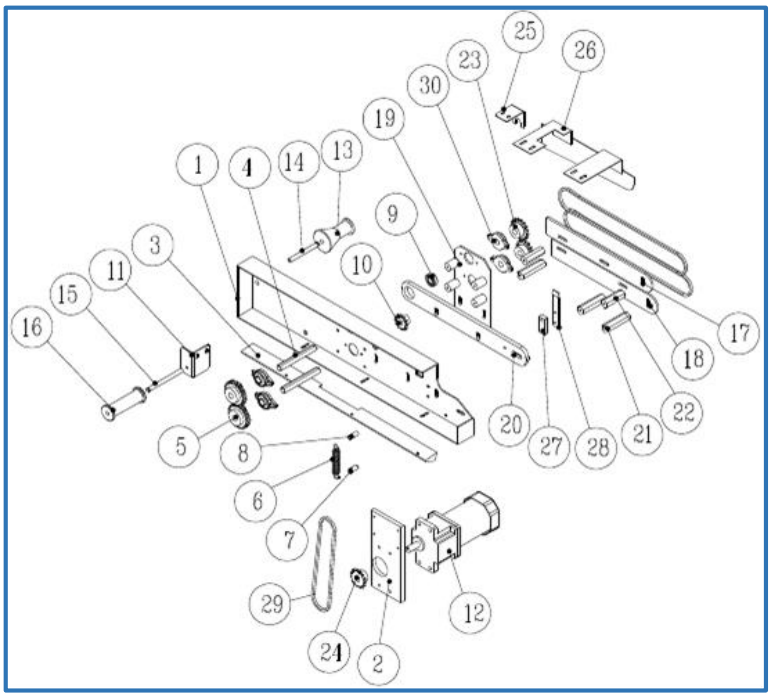
FILM TREATMENT GROUP

Nr.	Code	Description	Q.ty
1		Handle	1
2		Top fixing block	1
3		Up film unfolder installation frame	1
4		Up separating board	1
5		Ascending and descending bearing pedestal	1
6		Linear bearings	2
7		Ascending and descending nut	1
8		Unfolding film ascending and descendingguide rod	2
9		Up film unfolder ascending anddescending lead screw	1
10		Down separating film board	1
11		Down fixing board	1
12		Opposite photoelectricity	2
13		Photoelectricity frame	2
14		Left start photoelectricity frame	1
15		Right start photoelectricity frame	1
16		Guide rod fixing block	1
17		Bearing	3
18		Down photoelectricity frame	1
19		Up and down start photoelectricity	2
20		Up photoelectricity frame	1



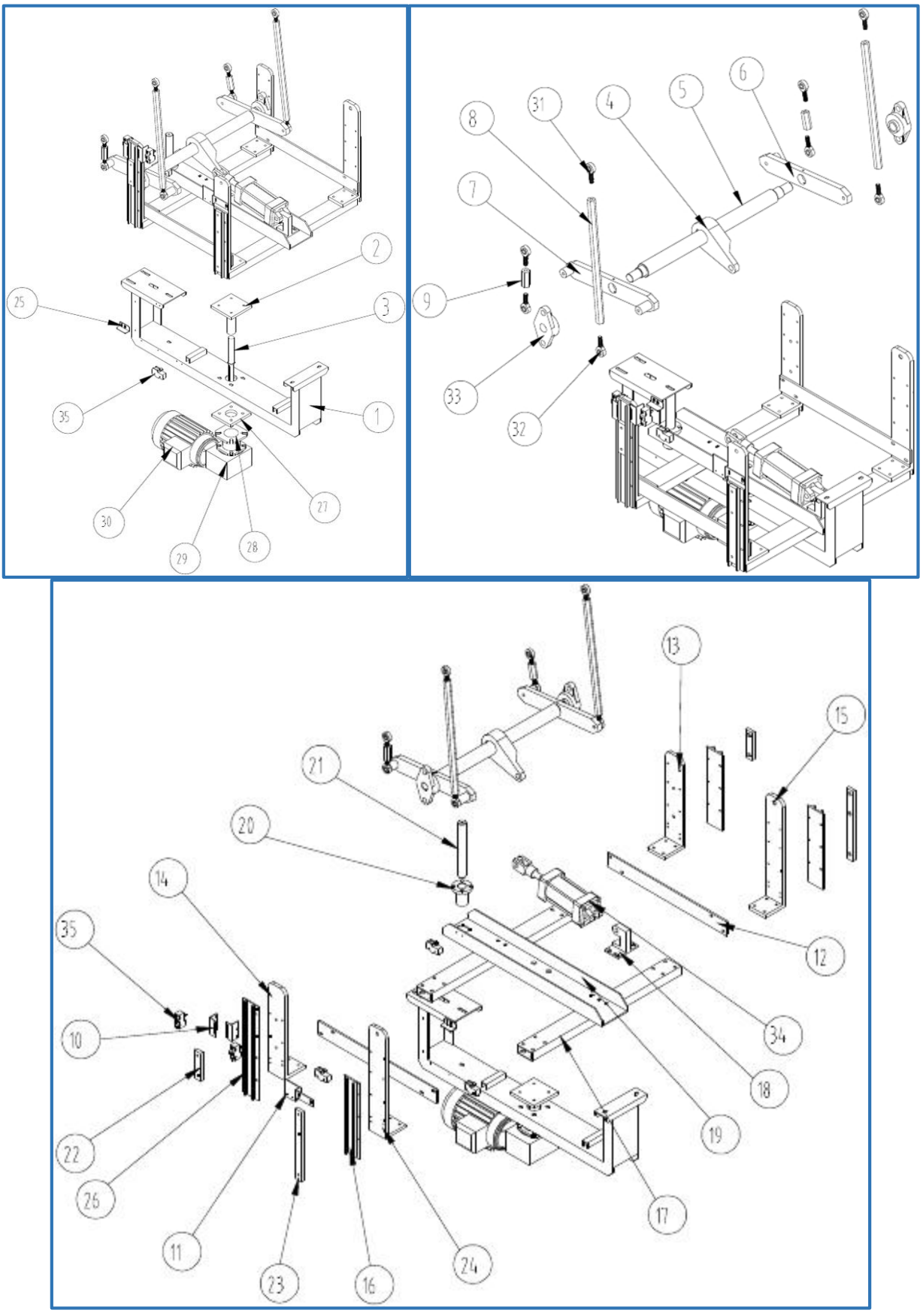
CONTROL PANEL

Nr.	Code	Description	Q.ty
1		Electric cabinet	1
2		Electric baseboard	1
3		Electric cabinet covering board	1
4		Electric panel	1



FILM COLLECTING GROUP

Nr.	Code	Description	Q.ty
1		Unserviceable film guiding frame	1
2		Motor board	1
3		Base board	1
4		Gear shaft	2
5		Gear	2
6		Tension spring	1
7		Tension spring pin 1	1
8		Tension spring pin 2	1
9		Bearing	1
10		Chain wheel	1
11		Transition wheel base 1	1
12		Motor	1
13		Transition wheel 2	1
14		Transition wheel shaftA	1
15		Transition wheel shaftB	1
16		Transition wheel 1	1
17		Chain board 1	1
18		Chain board 2	1
19		Bearing base board	1
20		Fixing board	1
21		Supporting pole 1	3
22		Supporting pole 3	3
23		Chain wheel 1	2
24		Chain wheel 2	1
25		Fixing covering board	1
26		Guarding board	1
27		Cushion block	1
28		Guarding slice	1
29		Chain	1
30		Bearing K002	4



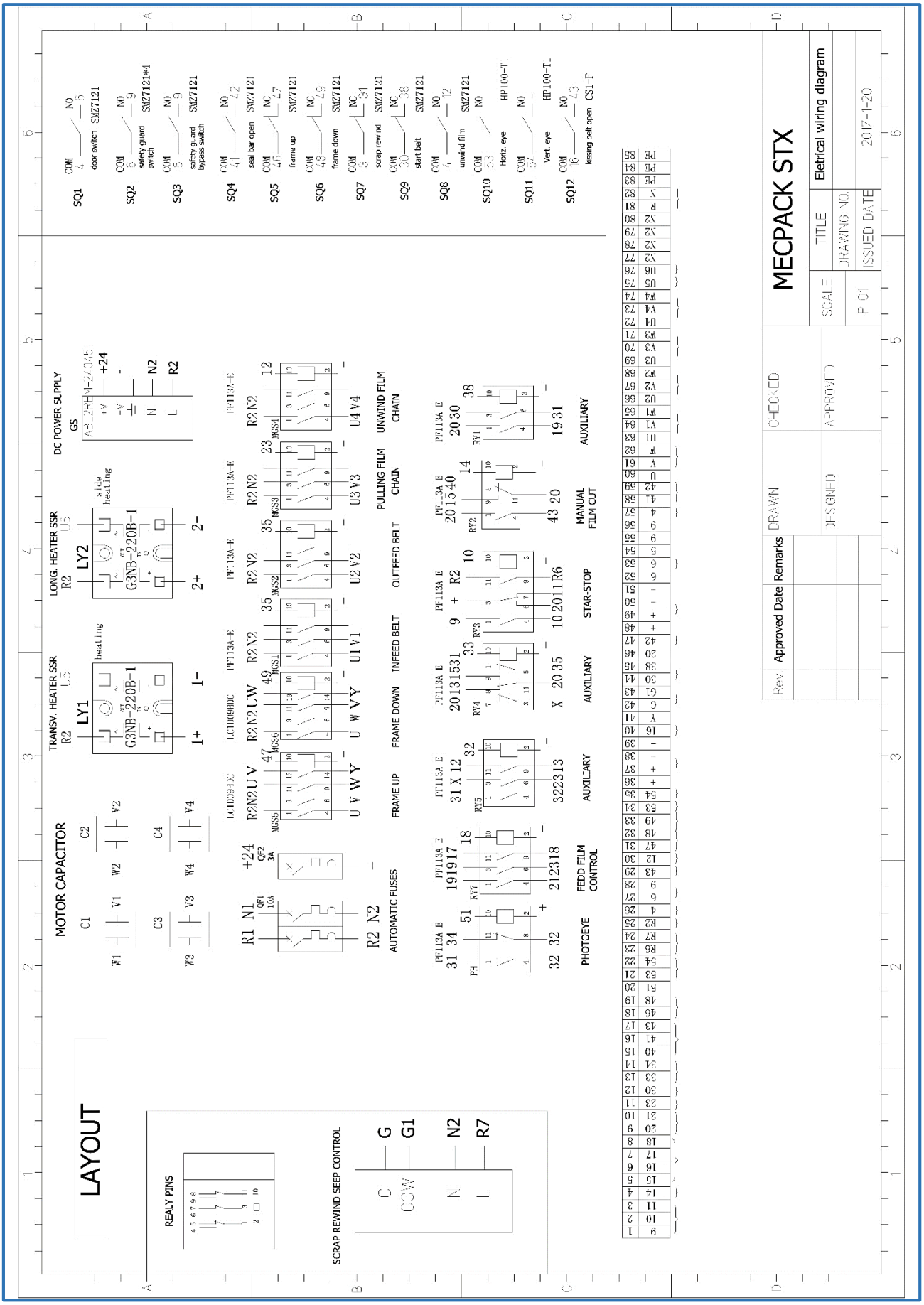
LIFTING UP AND DOWN GROUP

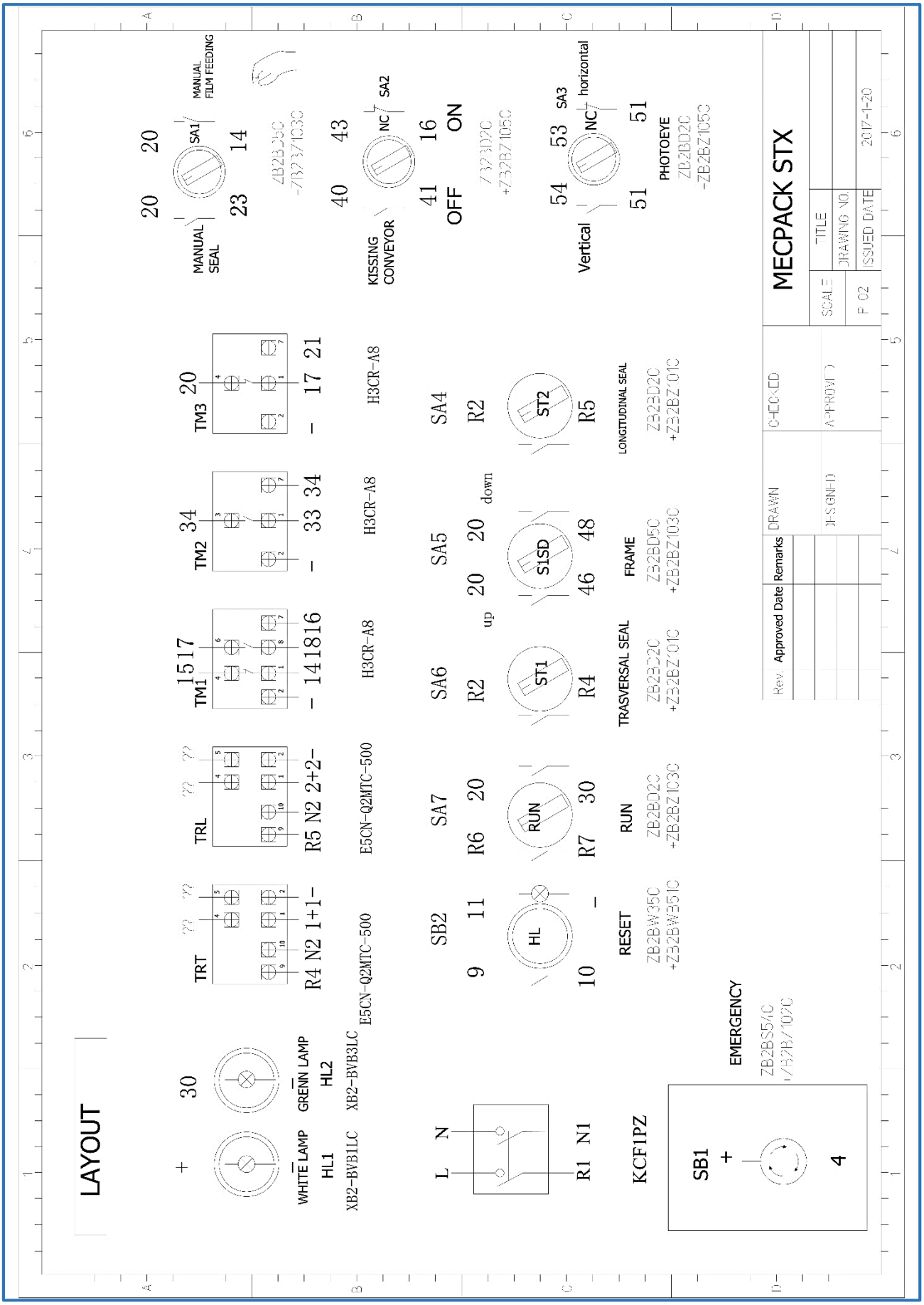
Nr.	Code	Description	Q.ty
1		Ascending and descending base	1
2		Ascending and descending pole	1
3		Ascending and descending motor axle	1
4		Opening and closing swaying block	1
5		Opening and closingswaying pole shaft	1
6		Opening and closing swaying pole 1	1
7		Opening and closing swaying pole 2	1
8		Long supporting pole	2
9		Short supporting pole	2
10		Limit switch fixing board 1	2
11		Limit switch fixing board 2	1
12		Connection board	2
13		Fixing base 1	1
14		Fixing base 2	1
15		Fixing base3	1
16		Sliding base 1	3
17		Horizontal connection board	2
18		Cylinder base	1
19		Cylinder installation board	1
20		Ascending and descending shaft sleeve	1
21		Ascending and descending fixing shaft	1
22		Sliding block1	2
23		Sliding block2	2
24		Fixing base 4	1
25		Limit switch fixing board 3	1
26		Sliding board 2	1
27		Ascending and descending motor base board	1
28		Flange 040	1
29		Reducer71B14-040	1
30		Motor	1
31		Oscillating bearing M10	4
32		Oscillating bearing M10opposite	4
33		Bearing pedestalUCP205	2
34		Cylinder	1
35		Micro active switch	5

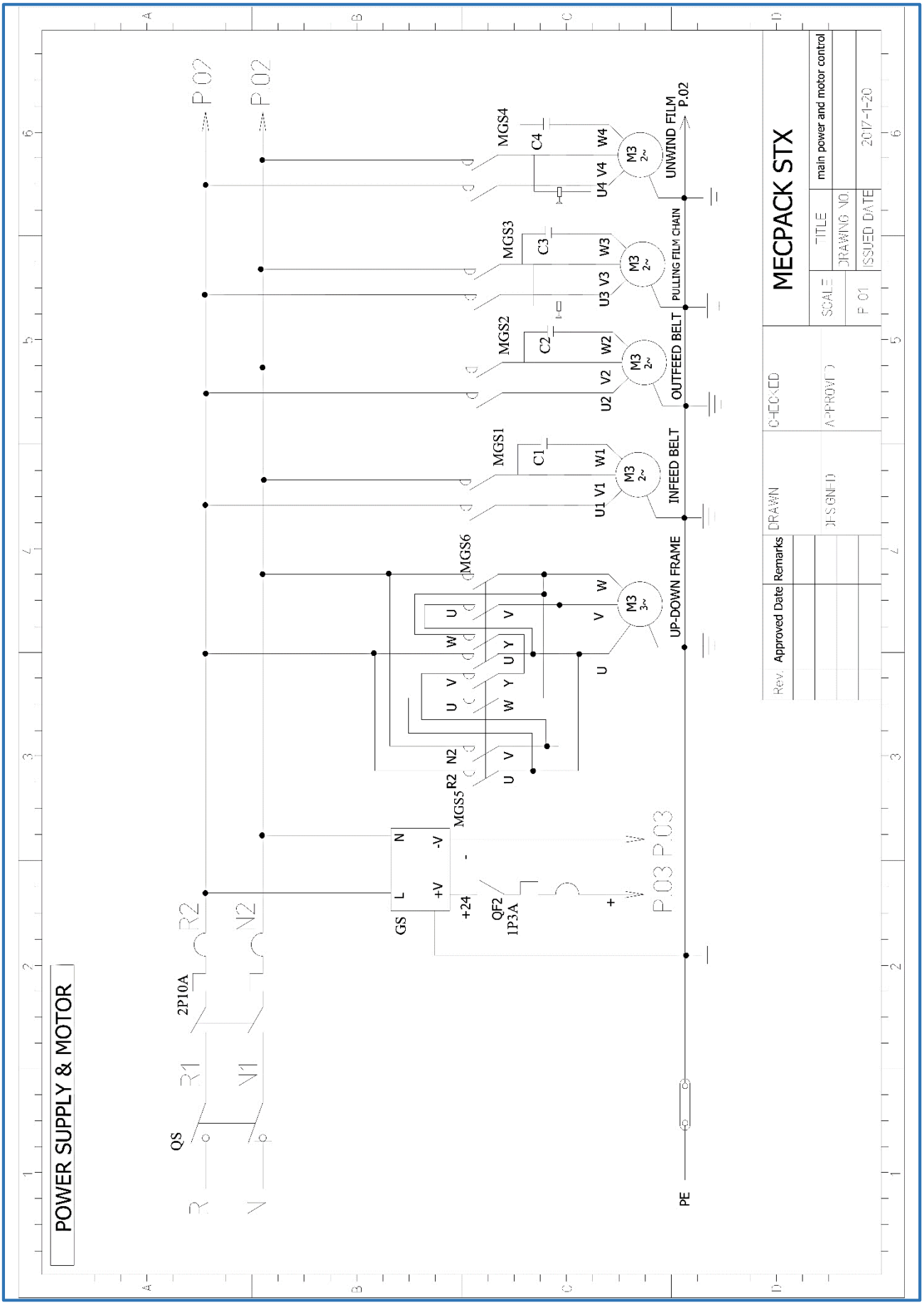
Fully Automatic «L» sealer

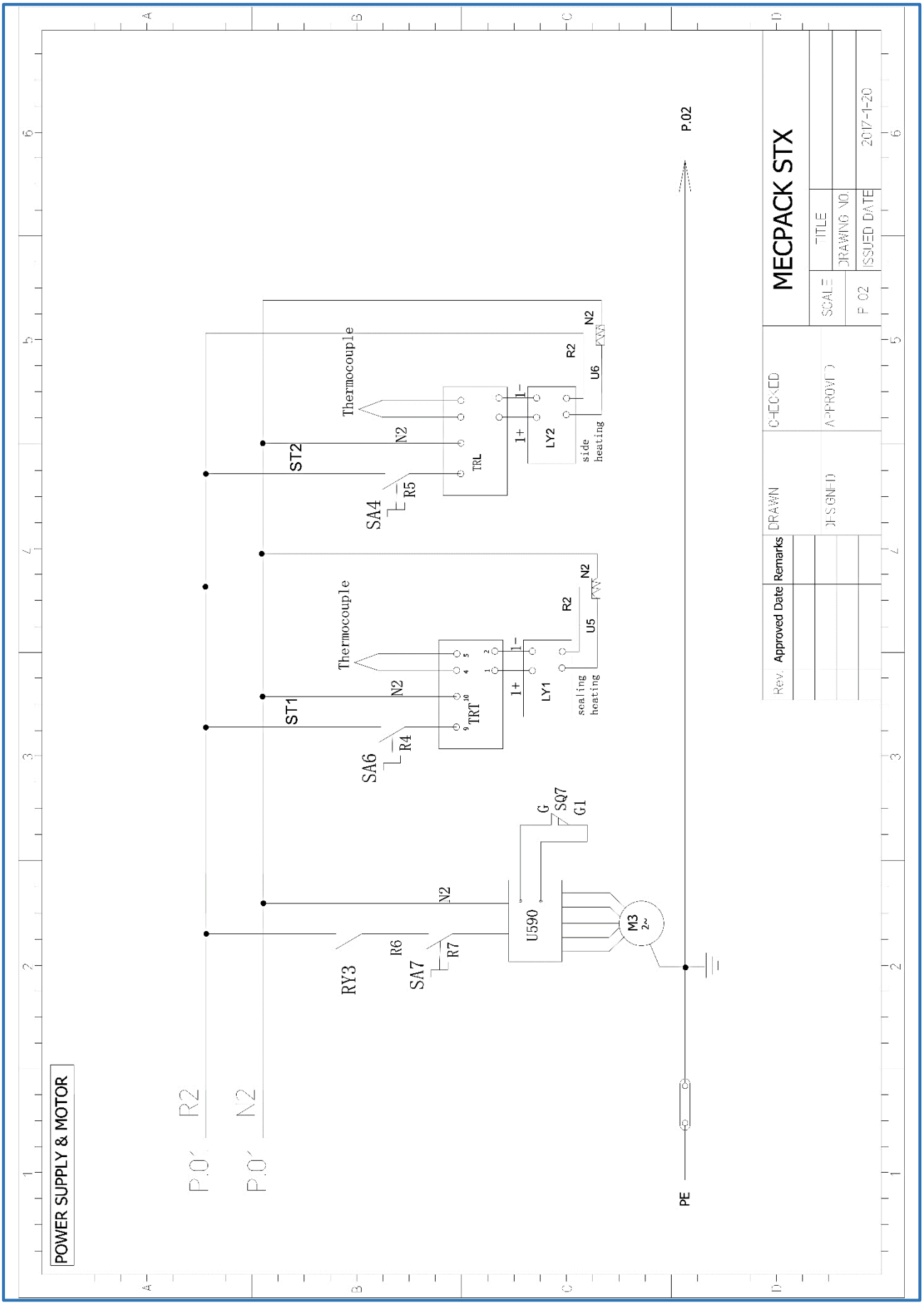
MECKPACK STX

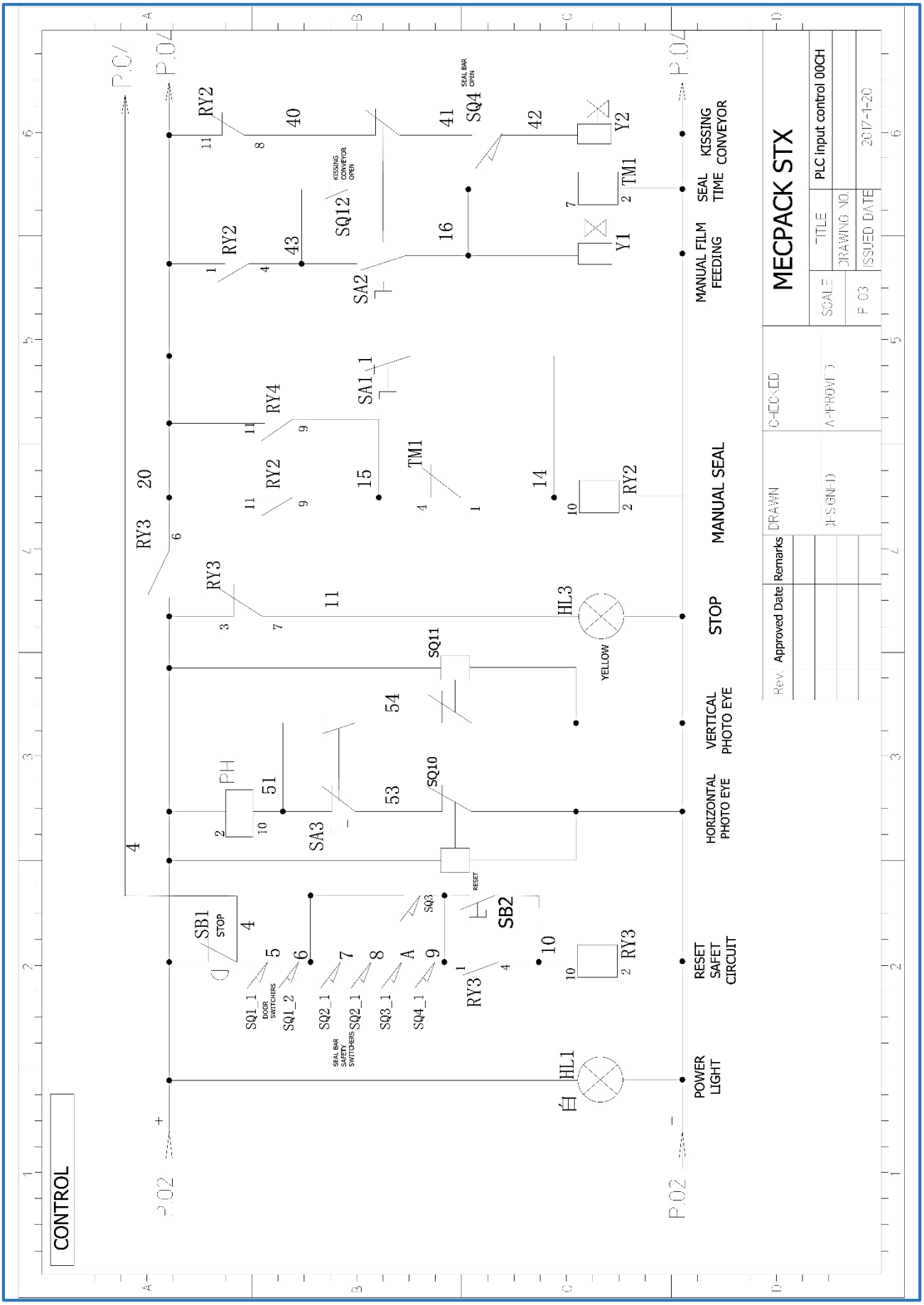
Wiring diagram

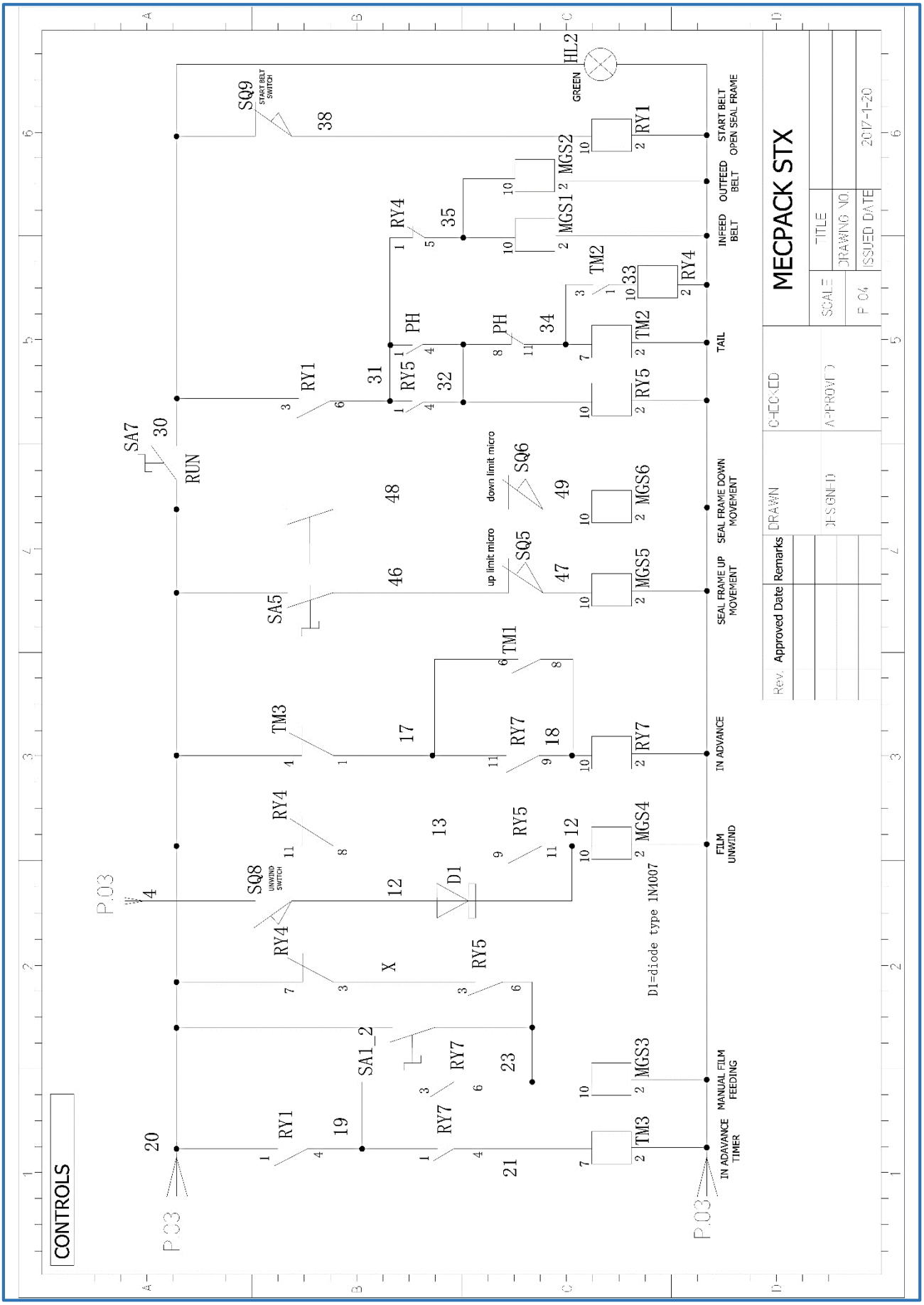

LAYOUT
MECPACK STX
Electrical wiring diagram
2017-1-20
DRAWN
CHECKED
APPROVED
DESIGNED
Rev.
Approved
Date
Remarks
SCALE
TITLE
DRAWING NO.
ISSUED DATE
MOTOR CAPACITOR
TRANSV. HEATER SSR
LONG. HEATER SSR
DC POWER SUPPLY
REALY PINS
SCRAP REWIND SEEP CONTROL
AUTOMATIC FUSES
PHOTOEYE
FEDD FILM CONTROL
FRAME UP
FRAME DOWN
INFEED BELT
OUTFEED BELT
PULLING FILM CHAIN
UNWIND FILM CHAIN
STAR-STOP
MANUAL FILM CUT
AUXILIARY
door switch
safety guard switch
safety guard bypass switch
seal bar open
frame up
frame down
start belt
scrap rewind
unwind film
Horiz. eye
Vert. eye
kissing belt open

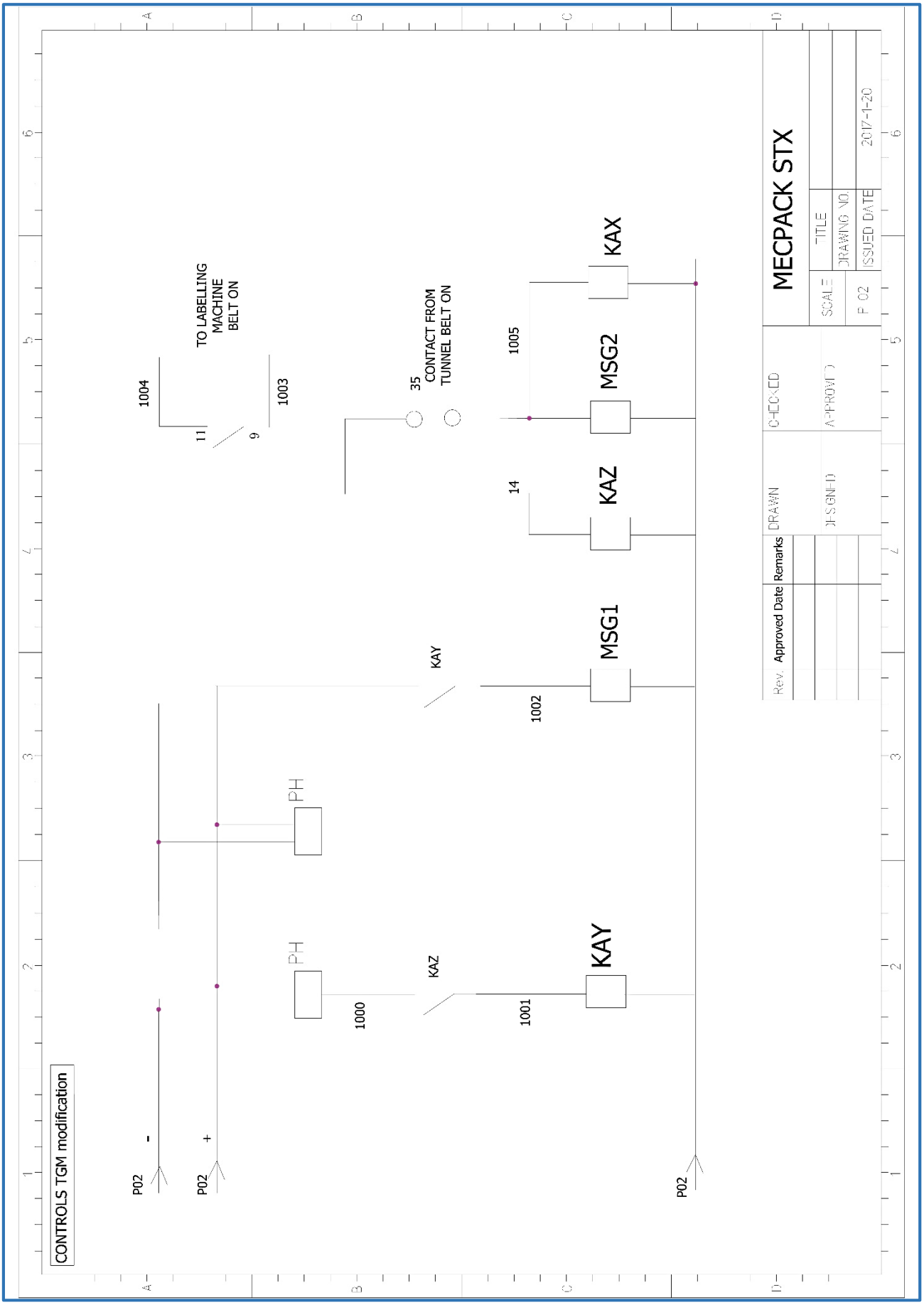

LAYOUT
MECPACK STX
MANUAL SEAL
MANUAL FILM FEEDING
KISSING CONVEYOR
OFF
ON
Vertical
horizontal
PHOTOEYE
WHITE LAMP
GREEN LAMP
HL1
HL2
RESET
RUN
EMERGENCY
SB1
KCF1PZ
TRT
TRL
TM1
TM2
TM3
SA1
SA2
SA3
SA4
SA5
SA6
SA7
ST1
ST2
S1SD
TRASVERSAL SEAL
LONGITUDINAL SEAL
FRAME
up
down
H3CR-A8
E5CN-Q2MTC-500
XB2-BVB1LC
XB2-BVB3LC
DRAWN
CHECKED
APPROVED
DESIGNED
Rev.
Approved Date
Remarks
SCALE
TITLE
DRAWING NO.
ISSUED DATE
2017-1-20


POWER SUPPLY & MOTOR
MECPACK STX
main power and motor control
2017-1-20
P.01
QS
R1
V1
R2
V2
2P10A
R
V
GS
QF2
1P3A
+24
MGS5
MGS6
MGS1
MGS2
MGS3
MGS4
C1
C2
C3
C4
INFEED BELT
OUTFEED BELT
PULLING FILM CHAIN
UNWIND FILM
UP-DOWN FRAME
P.02
P.03
PE


POWER SUPPLY & MOTOR
MECPACK STX
P.02
P.01 R2
P.01 N2
PE
ST1
ST2
SA4
SA6
SA7
RY3
R4
R5
R6
R7
TRT10
TRL
LY1
LY2
U5
U6
U590
M3
2~
SQ7
G
G1
N2
R2
Thermocouple
scaling heating
side heating
DRAWN
CHECKED
APPROVED
DESIGNED
Rev.
Approved Date
Remarks
SCALE
TITLE
DRAWING NO.
ISSUED DATE
2017-1-20


CONTROL
MECPACK STX
PLC input control 00CH
2017-1-20
MANUAL SEAL
STOP
VERTICAL PHOTO EYE
HORIZONTAL PHOTO EYE
RESET SAFET CIRCUIT
POWER LIGHT
MANUAL FILM FEEDING
SEAL TIME
KISSING CONVEYOR
SB1 STOP
SB2
SQ1_1 DOOR SWITCHERS
SQ1_2
SQ2_1 SEAL BAR SAFETY SWITCHERS
SQ2_1
SQ3_1
SQ4_1
SQ3
SQ10
SQ11
SQ12 KISSING CONVEYOR OPEN
SQ4 SEAL BAR OPEN
SA1_1
SA2
SA3
RY2
RY3
RY4
TM1
PH
HL1
HL3
YELLOW
Y1
Y2
RESET
P.02
P.04


CONTROLS
MECPACK STX
SCALE
TITLE
DRAWING NO.
ISSUED DATE
2017-1-20
F 04
CHECKED
APPROVED
DESIGNED
DRAWN
Rev.
Approved Date
Remarks
HL2
GREEN
SQ9
START BELT SWITCH
START BELT OPEN SEAL FRAME
OUTFEED BELT
INFEED BELT
TAIL
SEAL FRAME DOWN MOVEMENT
SEAL FRAME UP MOVEMENT
IN ADVANCE
FILM UNWIND
MANUAL FILM FEEDING
IN ADAVANCE TIMER
SA7
RUN
SA5
SA1_2
SQ8
UNWIND SWITCH
SQ5
up limit micro
SQ6
down limit micro
D1
D1=diode type 1N4007
RY1
RY4
RY5
RY7
TM1
TM2
TM3
PH
MGS1
MGS2
MGS3
MGS4
MGS5
MGS6
P.03


CONTROLS TGM modification
MECPACK STX
TITLE
DRAWING NO.
ISSUED DATE
2017-1-20
SCALE
F 02
CHECKED
APPROVED
DRAWN
DESIGNED
Rev. Approved Date Remarks
P02
-
+
PH
PH
KAY
KAZ
KAX
MSG1
MSG2
KAZ
KAY
1000
1001
1002
1003
1004
1005
14
11
9
35
TO LABELLING MACHINE BELT ON
CONTACT FROM TUNNEL BELT ON

Postadress:

TRÄDGÅRDSTEKNIK AB
Helsingborgsvägen 578, Varalöv
262 96 ÄNGELHOLM

Telefon : 0431-222 90
Bg.nr : 5743-7980
Org.nr : 556409-6120

URL:

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info@tradgardsteknik.se